

# *Grizzly* *Industrial, Inc.*®

## MODEL G0524 RIP SAW OWNER'S MANUAL



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#DS5689 PRINTED IN TAIWAN

# WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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# SECTION 1: SAFETY

## WARNING

### For Your Own Safety Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.

Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.



**NOTICE**

This symbol is used to alert the user to useful information about proper operation of the equipment.

## WARNING

### Safety Instructions for Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form a habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **NEVER USE IN DANGEROUS ENVIRONMENT.** DO NOT use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept at a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **NEVER FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** DO NOT force tool or attachment to do a job for which it was not designed.

# WARNING

## Safety Instructions for Power Tools

- 9. USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

AMP RATING	LENGTH		
	25ft	50ft	100ft
0-6	16	16	16
7-10	16	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

- 10. WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
- 11. ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 12. SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.
- 13. DO NOT OVER-REACH.** Keep proper footing and balance at all times.
- 14. MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

- 15. USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

- 16. REDUCE THE RISK OF UNINTENTIONAL STARTING.** On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

- 17. CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

- 18. NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** DO NOT leave tool until it comes to a complete stop.

- 19. NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.

- 20. NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to machine operation are approved, correct, safe, and clearly understood.

- 21. IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES** performing the intended operation, stop using the machine! Then contact our service department or ask a qualified expert how the operation should

## **WARNING**

### **Additional Safety Instructions for Rip Saws**

1. **BLADE GUARD.** Always use the blade guard on all cutting operations.
2. **KICKBACK.** Be familiar with kickback. Kickback happens when the workpiece is thrown towards the operator at a high rate of speed. *Until you have a clear understanding of kickback and how it occurs, DO NOT operate this saw!*
3. **WORKPIECE CONTROL.** Make sure the workpiece is placed in a stable position on the table and is supported by the rip fence during cutting operations.
4. **SAFETY ACCESSORIES.** Use safety glasses, a respirator, and hearing protection to make cutting operations safe.
5. **OPERATOR POSITION.** Never stand or have any part of your body directly in-line with the cutting path of the saw blade.
6. **STALLED BLADE.** Turn the saw off and disconnect from the power source before attempting to "free" a stalled saw blade.
7. **COMFORTABLE CUTTING OPERATIONS.** Avoid awkward operations and hand positions where a sudden slip could cause your hand to move into the conveyor track.
8. **EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Service Department at (570) 546-9663.
9. **DAMAGED SAW BLADES.** Never use blades that have been dropped or damaged; otherwise, serious personal injury could occur.

## **WARNING**

Like all machines there is danger associated with the Model G0524. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

## **CAUTION**

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

# SECTION 2: INTRODUCTION

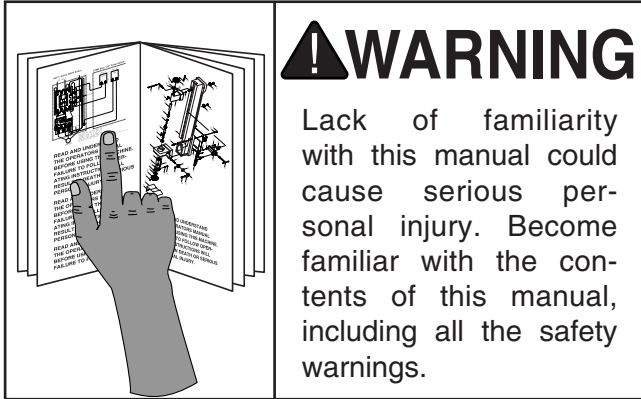
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## Commentary

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We are proud to offer the Model G0524 Rip Saw. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0524. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible. If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.  
% Technical Documentation  
P.O. Box 2069  
Bellingham, WA 98227-2069

Most importantly, we stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.  
1203 Lycoming Mall Circle  
Muncy, PA 17756  
Phone: (570) 546-9663  
Fax: (800) 438-5901  
E-Mail: [techsupport@grizzly.com](mailto:techsupport@grizzly.com)  
Web Site: <http://www.grizzly.com>

The specifications, drawings, and photographs illustrated in this manual represent the Model G0524 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at [www.grizzly.com](http://www.grizzly.com). Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!



# SECTION 3: CIRCUIT REQUIREMENTS

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## Voltage & Amperage Draw

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The following list outlines the electrical phase and voltage required to operate the rip saw, as well as the amperage draw of the motors:

### Pre-Wired For 220V, 3-Phase

15 HP Main Motor .....	37 Amps
2 HP Feed Motor .....	6 Amps

### Rewired For 440V, 3-Phase

15 HP Main Motor .....	18.5 Amps
2 HP Feed Motor .....	3 Amps



## Circuit Breaker

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Use the following guidelines when choosing a circuit breaker (circuit breakers rated any higher are not adequate to protect the circuit):

220V 3-Phase .....	45 Amp, 3 Pole
440V 3-Phase.....	25 Amp, 3 Pole



## Connection Type

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Because of the high amperage draw from this machine, we recommend that you hardwire it directly to your circuit breaker and install a locking shut-off lever (**Figure 1**) near the machine as a way to quickly disconnect the power.

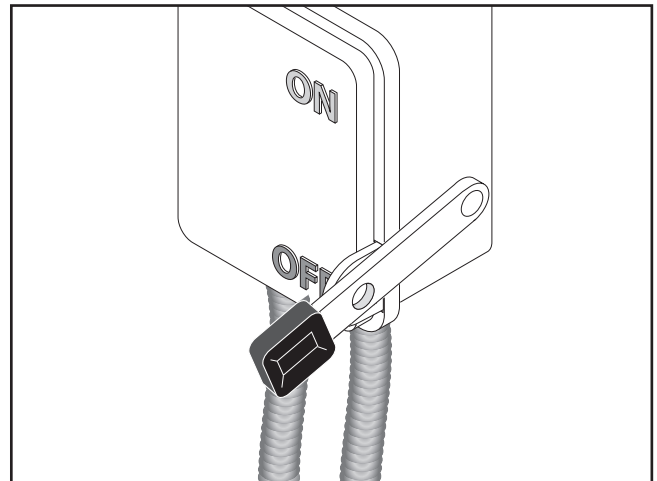


Figure 1. Locking shut-off lever.



## Circuit Capacity

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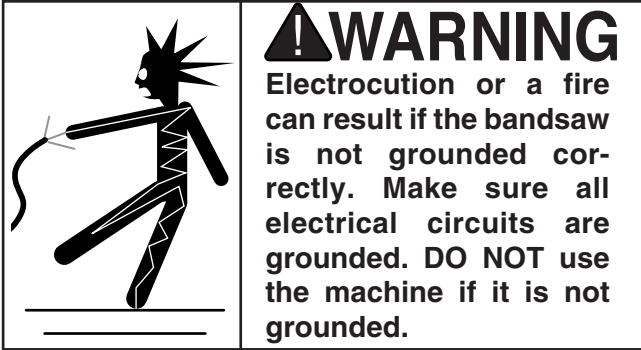
Always check to see if the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician.

If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified electrician.





# Grounding



In the event of an electrical short, grounding provides electric current a path of least resistance to reduce the risk of electrical shock to the operator. Ground the power cord and this machine in accordance with all local codes and ordinances.

Operating this machine when it is not properly grounded can result in electric shock or electrocution.



# Rewire To 440V (3-Phase)

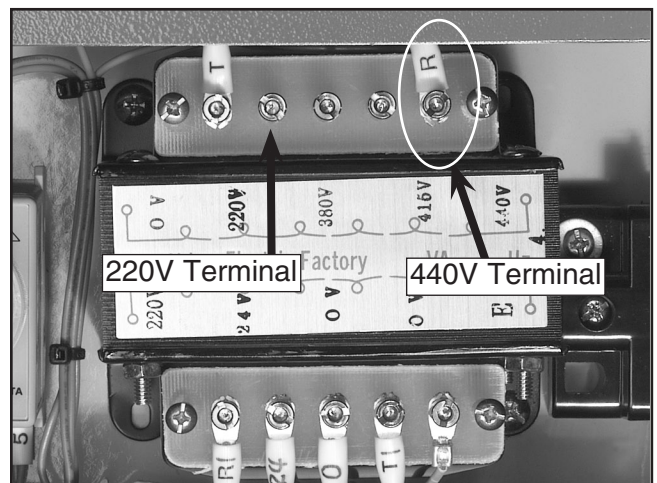
The Model G0524 can be rewired for 440V 3-phase operation. This rewiring job consists of disconnecting the rip saw from the power source, changing the connections on the voltage transformer, changing the overload relays for the motors, and rewiring the motors.

The necessary overload relays for this procedure can be purchased in the Model G0524 440V Conversion Kit (P/N P0524067) by calling our customer service number at (800) 523-4777.

This procedure takes moderate electrical skill and the rewiring job must be inspected by a licensed electrician before the saw is connected to the power source.

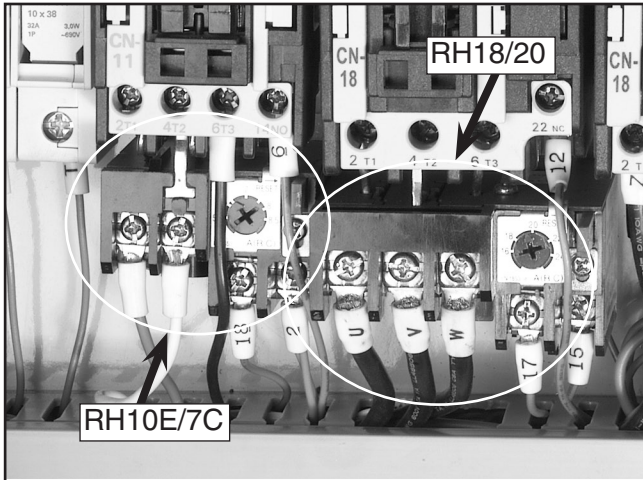
## To rewire the Model G0524 to 440V 3-Phase:

1. **Disconnect the rip saw from the power source!**
2. Open the electrical box.
3. Remove the wire labeled “R” at the 220V terminal of the power transformer and connect it to the 440V terminal (**Figure 2**).



**Figure 2.** The “R” wire is connected to the 440V terminal post to operate the rip saw on a 440V 3-phase power source.

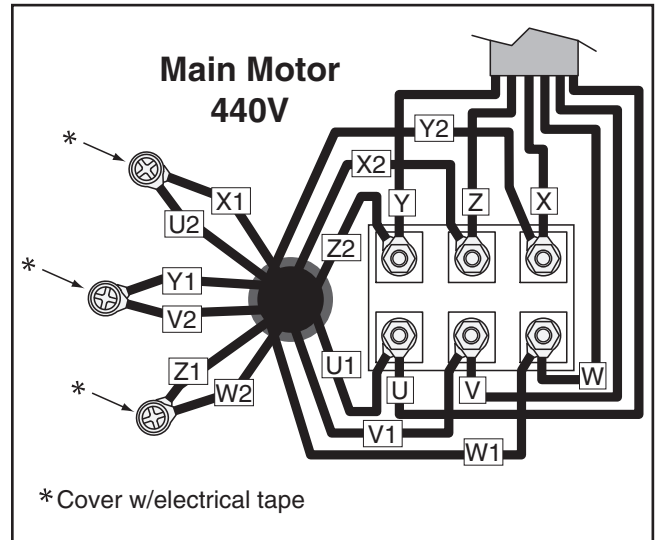
- Remove the RH10E/7C overload relay (**Figure 3**) and replace it with an RH10E/4C (3-5A) type, with the dial set to 4A.
- Remove the RH18/20 overload relay (**Figure 3**) and replace it with an RH18/15 (12-18A) type, with the dial set to 12A.



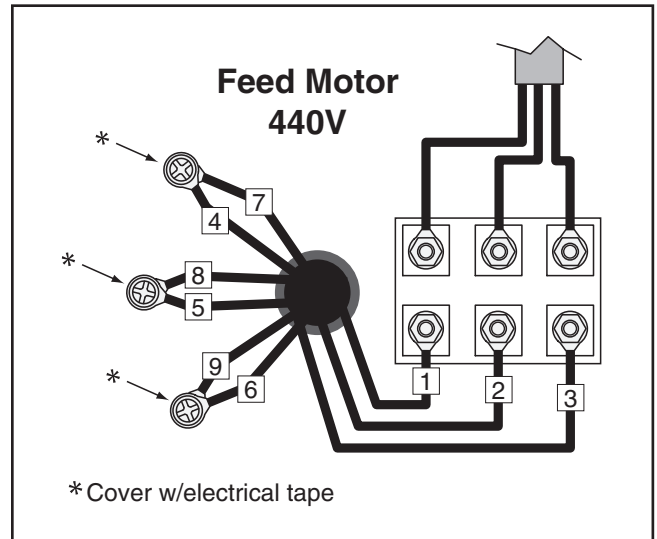
**Figure 3.** Overload relays.

- Wire the main motor and the feed motor as shown on the diagrams on the inside of each motor wire cover. After connecting wires together with the screws, nuts, and washers provided in the 440V conversion kit, completely wrap the connecting hardware in electrical tape so no metal is exposed where the wires connect.

**Note—***Figures 4a and 4b have been provided for your reference and were current at the time that this manual was written. However, always use the diagram on the wire cover that comes with your motor!*



**Figure 4a.** 440V main motor wiring.



**Figure 4b.** 440V feed motor wiring.



# SECTION 4: FEATURES & CONTROLS

## External Features

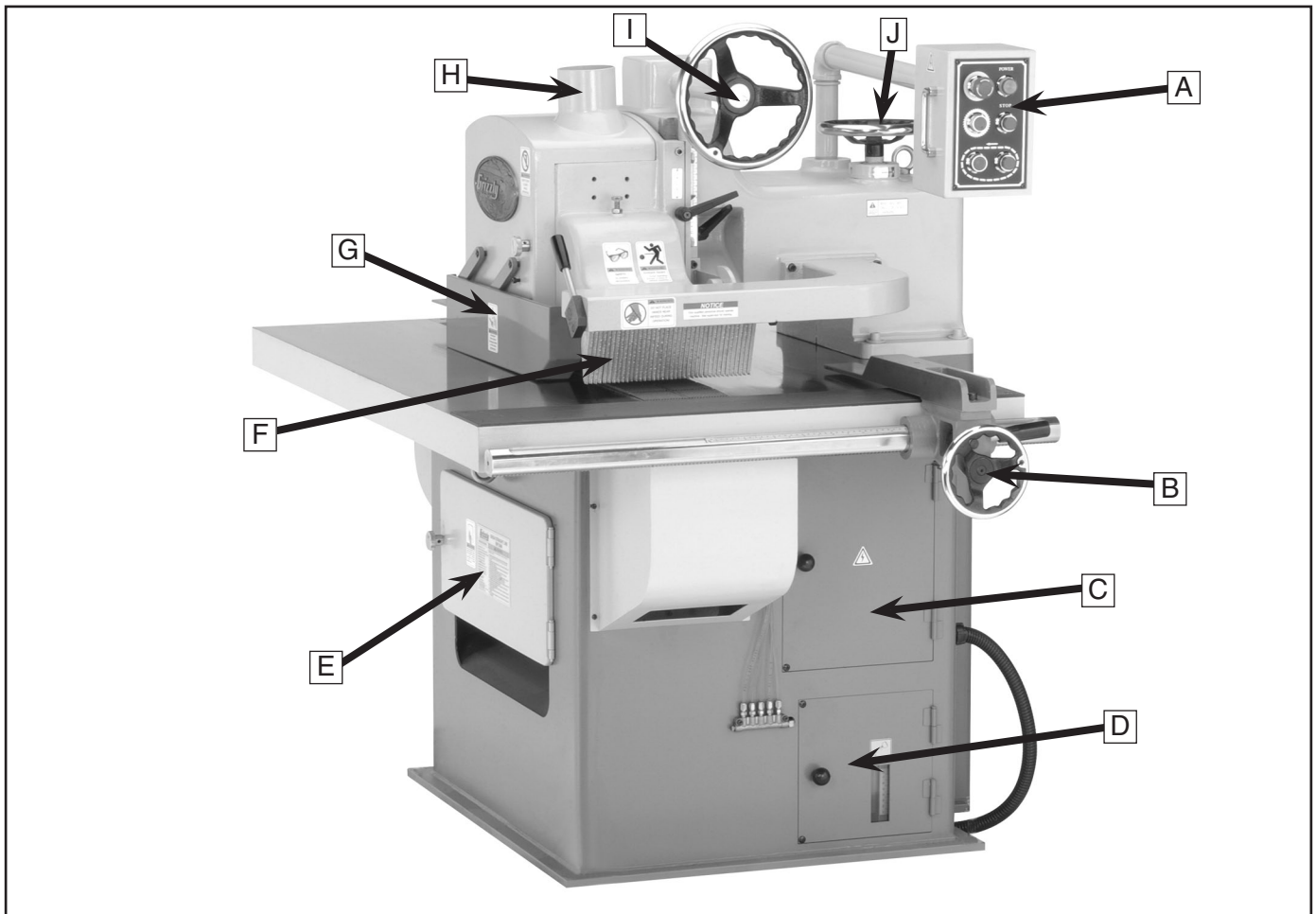


Figure 5. Front View.

- A. **Control Panel**—Location of the START & STOP buttons that power the saw.
- B. **Fence Handwheel**—Moves the rip fence along the fence rail.
- C. **Electrical Access Door**—Provides access to the electrical components.
- D. **Oil Reservoir Access Door**—Provides access to the oil reservoir.
- E. **Lower Conveyor Track Access Door**—Provides access to the conveyor track and the lubrication brushes.
- F. **Anti-Kickback Fingers**—Prevents the workpiece from being ejected out of the saw towards the operator.
- G. **Blade Guard**—Protects the operator and bystanders from the saw blade.
- H. **Dust Port**—4" dust hook-up for efficient dust extraction from the cutting operation.
- I. **Pressure Roller Height Handwheel**—Adjusts the height of the pressure roller assembly.
- J. **Blade Height Handwheel**—Adjusts the height of the saw blade. Note—*Only adjust the handwheel when making blade changes.*

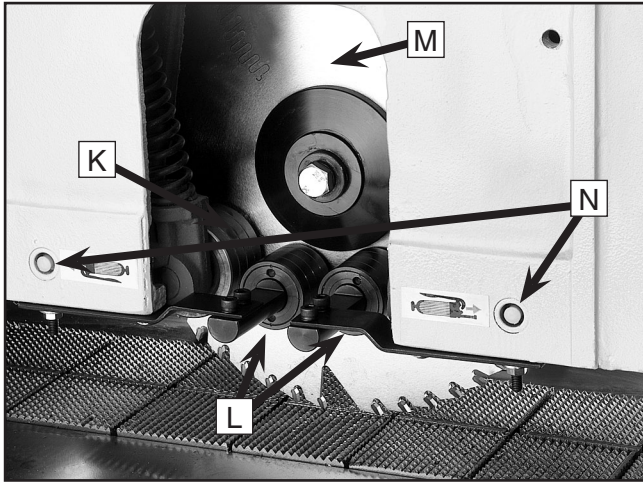


Figure 6. Blade compartment close-up.

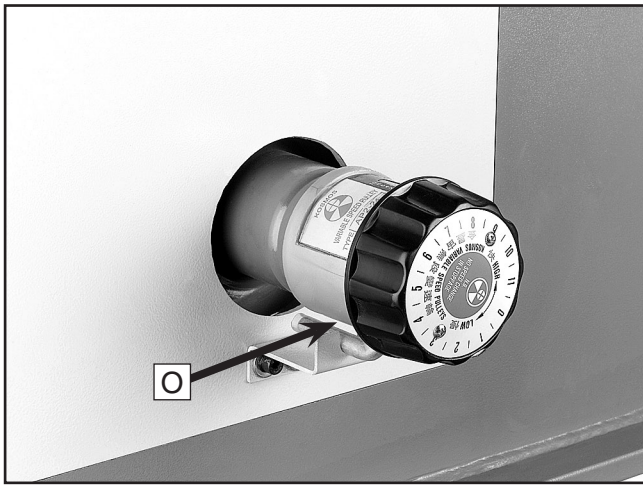


Figure 7. Variable speed knob close-up.

- K. **Pressure Rollers**—(1 of 4) Holds the workpiece against the conveyor track during the cutting operation.
- L. **Auxiliary Pressure Rollers**—(2 of 4) Must be used when rip cutting workpieces shorter than 8½" long.
- M. **Saw Blade**—Performs the cutting operation.
- N. **Lubrication Points**—(2 of 4) Grease fittings that need to be lubed periodically with a grease gun.
- O. **Variable Speed Adjustment Knob**—Turn the dial clockwise to decrease the feed rate and counterclockwise to increase it. The feed rate is variable between 30-112 FPM.



## Control Panel

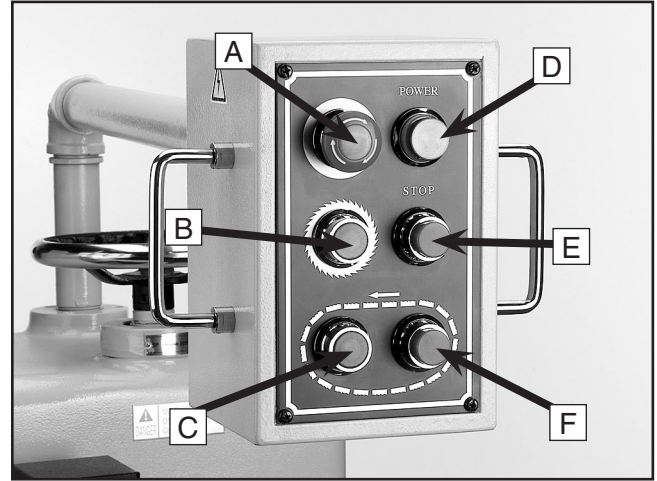


Figure 8. Control panel.

- A. **EMERGENCY STOP Button**—Disconnects power to all motors in the motor cabinet.
- B. **MAIN MOTOR START Button**—Starts the saw blade.
- C. **FEED MOTOR START Button**—Starts the conveyor track.
- D. **POWER Light**—Indicates there is power to the control panel.
- E. **MAIN MOTOR STOP Button**—Stops the saw blade.
- F. **FEED MOTOR STOP Button**—Stops the conveyor track.



# SECTION 5: SET UP

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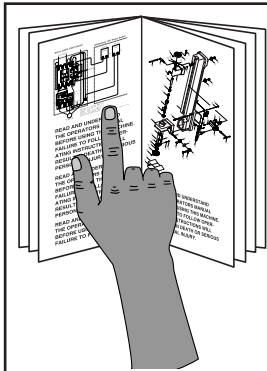
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## About this Section

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The purpose of this section is to guide you through the required steps to get your machine out of its packaging and into operating condition.

	<p><b>! WARNING</b> This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!</p>
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	<p><b>! WARNING</b> Wear safety glasses during the entire set up process!</p>
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## Unpacking

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The Model G0524 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the parts.



# Loose Parts Inventory

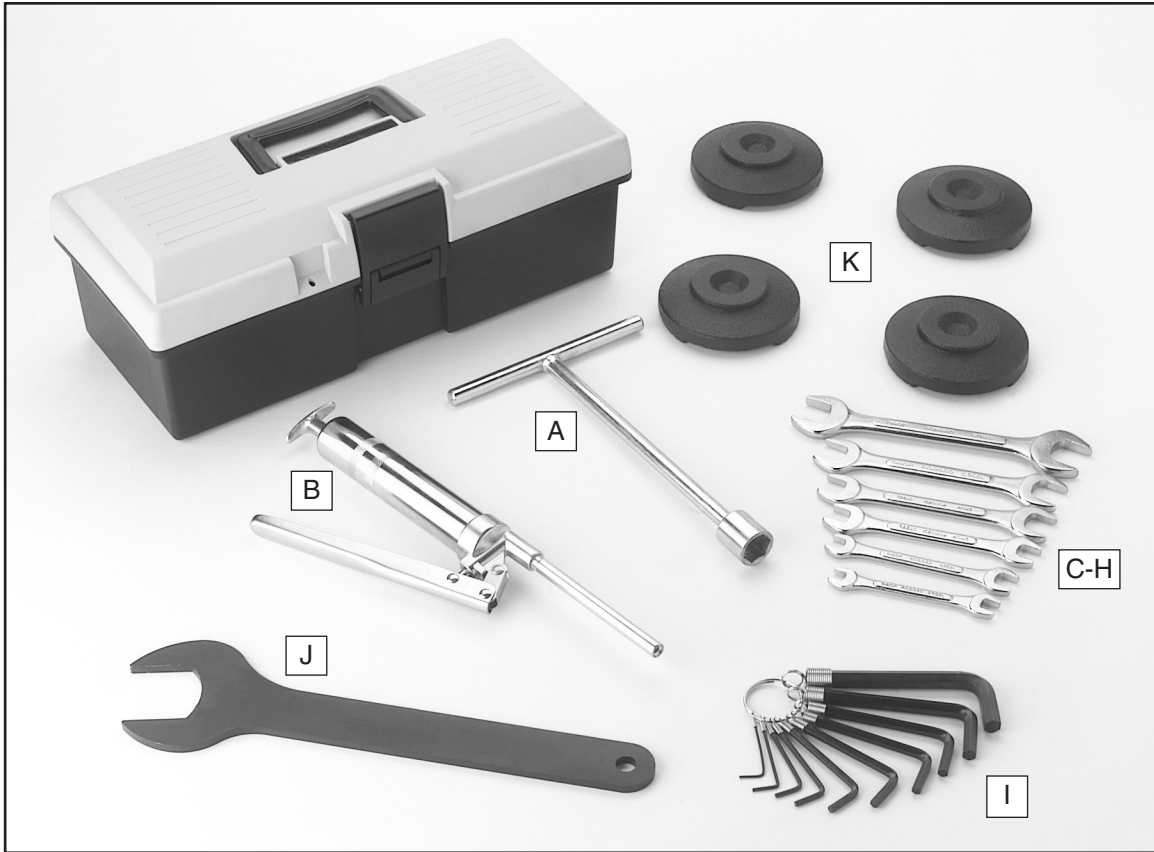
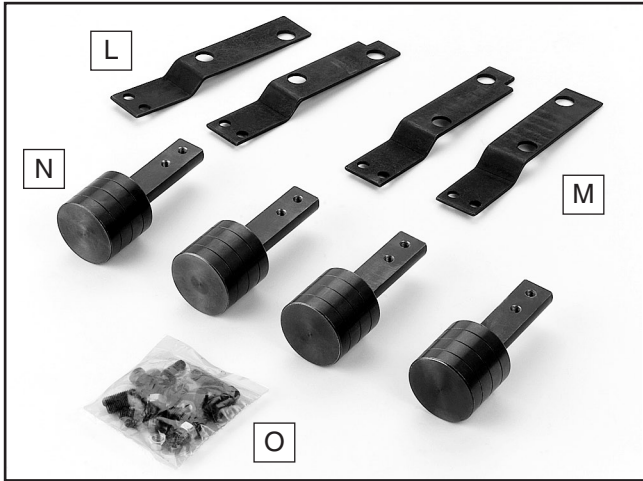


Figure 9. Tool Box Contents.

DESCRIPTION	QTY
A. T-Handle Wrench 19mm .....	1
B. Grease Gun .....	1
C. Combo Wrench 8 x 10mm .....	1
D. Combo Wrench 10 x 12mm .....	1
E. Combo Wrench 11 x 13mm .....	1
F. Combo Wrench 14 x 17mm .....	1
G. Combo Wrench 17 x 19mm .....	1
H. Combo Wrench 22 x 24mm .....	1
I. 10 pc Allen Wrench Set (1.5-10mm) .....	1
J. Arbor Wrench 45mm .....	1
K. Cast Iron Feet.....	4



**Figure 10.** Auxiliary Roller Box Contents.

DESCRIPTION	QTY
L. Auxiliary Roller Brackets (Left) .....	2
M. Auxiliary Roller Brackets (Right) .....	2
N. Auxiliary Rollers .....	4
O. Hardware Bag .....	1



**Figure 11.** Hardware Bag Contents.

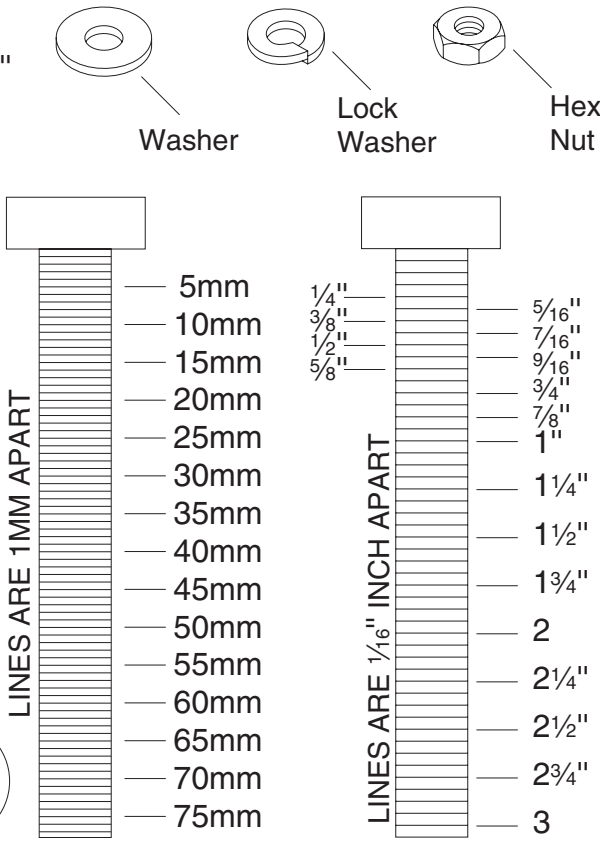
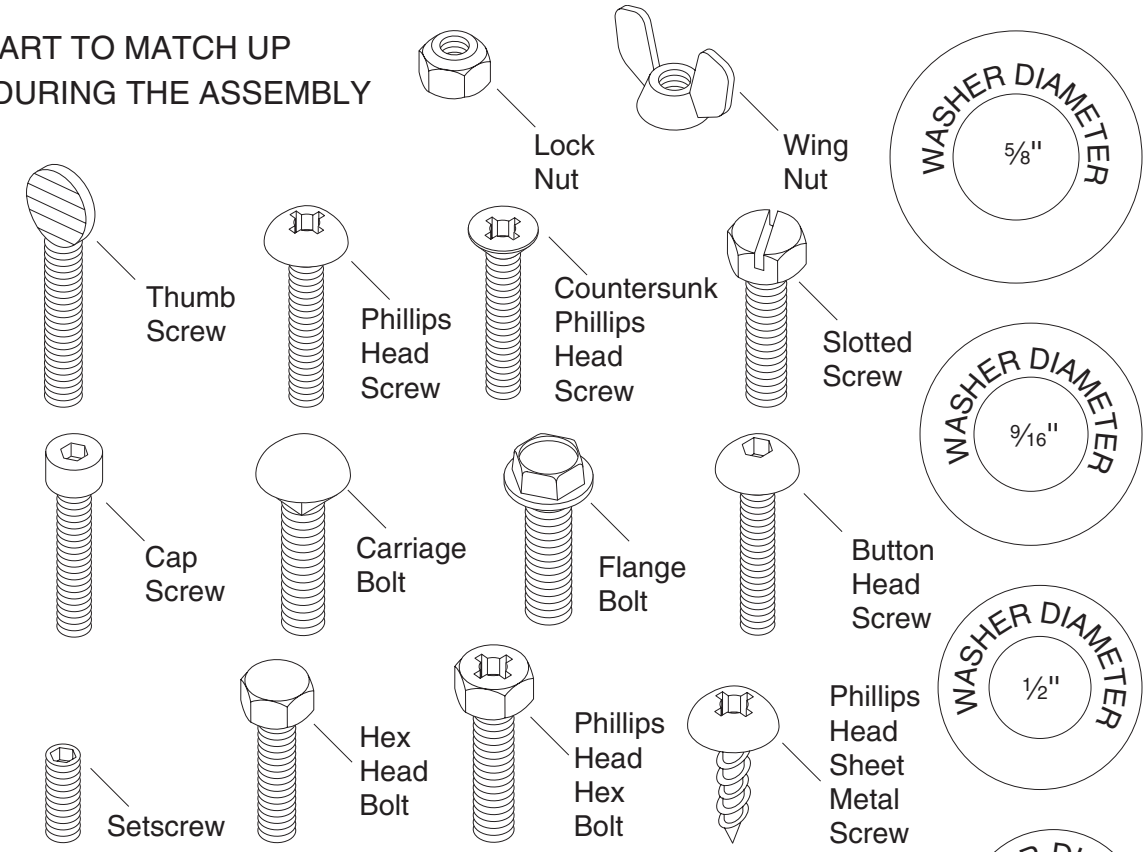
DESCRIPTION	QTY
P. Cap Screws M6-1.0 x 16 .....	8
Q. Setscrews M6-1.0 x 30 .....	4
R. Lock Washers 6mm .....	8
S. Flat Washers 6mm .....	4
T. Hex Nuts 6-1.0 .....	4

# Hardware Recognition Chart

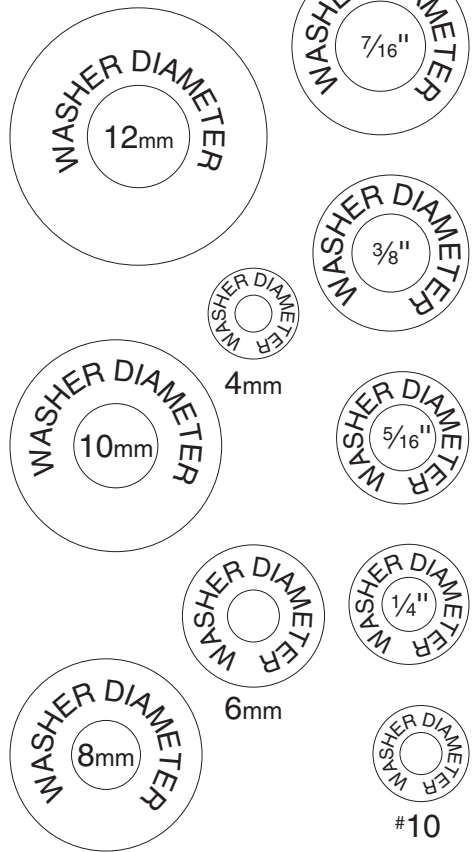
USE THIS CHART TO MATCH UP  
HARDWARE DURING THE ASSEMBLY  
PROCESS!

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"
- 5/8"
- 4mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm



WASHERS ARE MEASURED BY THE INSIDE DIAMETER





# Site Considerations

## Floor Load

The Model G0524 weighs 1980 lbs. Most commercial floors are suitable for your machine. Some floors may require additional reinforcement to support the machine, the operator, and the workpiece.

## Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your saw. See **Figure 12** for the footprint of the Model G0524.

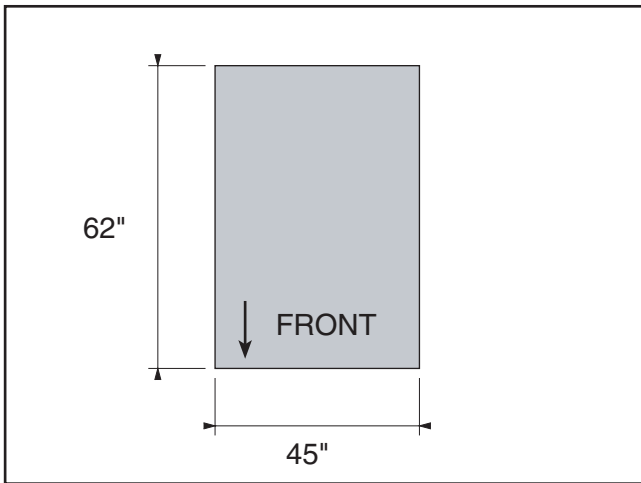



Figure 12. Model G0524 footprint.


	<p><b>! WARNING</b></p> <p>Unsupervised children and visitors inside your shop could receive serious personal injury. Ensure child and visitor safety by keeping all entrances to the shop locked at all times. <b>DO NOT</b> allow unsupervised children or visitors in the shop at any time.</p>
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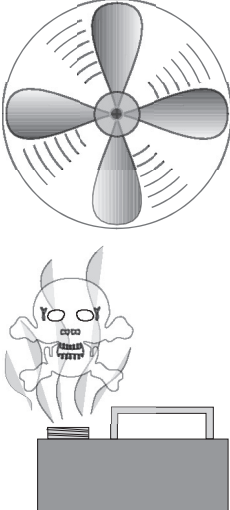


# Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact.


	<p><b>! WARNING</b></p> <p>Gasoline and petroleum products have low flash points and could explode if used to clean machinery. <b>DO NOT</b> use gasoline or petroleum products to clean the machinery.</p>
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	<p><b>! WARNING</b></p> <p>Smoking near solvents could ignite an explosion or fire and cause serious injury. <b>DO NOT</b> smoke while using solvents.</p>
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	<p><b>! WARNING</b></p> <p>Lack of ventilation while using solvents could cause serious personal health risks, fire, or environmental hazards. Always work in a well ventilated area to prevent the accumulation of dangerous fumes. Supply the work area with a constant source of fresh air.</p>
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# Placement

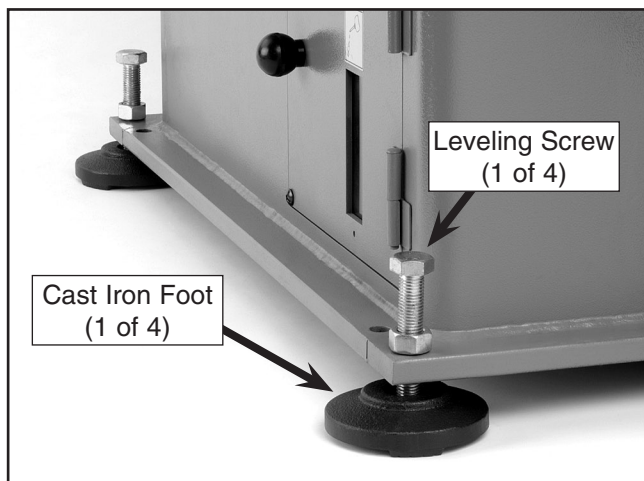


## WARNING

The Model G0524 is a heavy machine that weighs approximately 1980 lbs. Serious personal injury may occur if safe moving methods are not followed. Use the assistance of power equipment when moving the crate and placing the machine.

To remove the saw base unit from the crate pallet:

1. Cut off and remove all plastic straps from the crate.
2. Using a forklift, position the saw over the final location.
3. Place the cast iron feet under the leveling screws.
4. Lower the saw onto the cast iron feet as shown in **Figure 13**.



**Figure 13.** Cast iron feet.

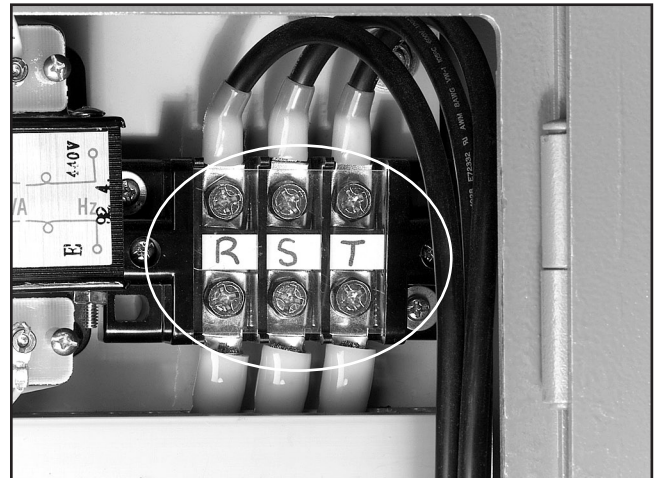
5. Adjust the leveling screws until the saw table is level.



# Power Cord

To connect the power cord to the saw:

1. Read through *Section 3: Circuit Requirements* to double-check that your setup follows the safety and circuit requirements, and that the power cord you use meets the minimum requirements for this machine.
2. Open the electrical panel box.
3. Feed the power cord through the strain relief on the side of the electrical panel, and connect the cord wires to the main terminal (**Figure 14**).



**Figure 14.** Main terminal located inside saw electrical panel.

4. Close the electrical panel door.
5. **DO NOT connect the power cord to the power source at this time.**



# Remove The Blade

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For safety reasons, the saw blade must be removed before the saw is test run to ensure the wiring is not reversed at the main terminal (Figure 14). If the wiring is reversed, the saw arbor and the conveyor track will run in the wrong direction.

## CAUTION

The saw blade is very sharp and can cause personal injury. Always wear thick leather gloves when working on or around the saw blade.

### To remove the blade:

1. **If not already done, make sure the saw is not connected to the power source!**
2. Loosen the saw arbor lock lever.
3. Using the blade height handwheel, raise the blade until it is approximately ¼" above the conveyor track.
4. Open the blade access door.
5. Using the arbor wrench, hold the blade arbor stationary.
6. Using the T-handle wrench, remove the arbor bolt by rotating it counterclockwise.
7. Remove the large blade flange and carefully slide the blade off the arbor.
8. **DO NOT re-install the arbor bolt or flange at this time.**



# Test Run

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## WARNING

Before starting the saw, make sure you have removed the saw blade, performed the preceding assembly and adjustment instructions, and have read through the rest of the manual and are familiar with the various functions and safety issues associated with this machine. Failure to follow this warning could result in serious personal injury or even death!

### To test run the saw:

1. Connect the power cord to an adequate power source.
2. Put on safety glasses and make sure any bystanders are out of the way and are also wearing safety glasses.
3. At the front of the control panel, rotate the red EMERGENCY STOP button until it springs up. The control panel is now live and any buttons you push will react accordingly.
4. Press the MAIN MOTOR START button. The arbor should start and run smoothly.
5. The arbor should spin counterclockwise.
  - If the arbor spins counterclockwise, then skip ahead to the **step 6**.

## CAUTION

**DO NOT** turn the conveyor track **ON** if the arbor rotates clockwise. Reverse any two of the power wires at the main terminal.

- If the arbor spins clockwise, **DO NOT** start the conveyor track. Press the red EMERGENCY STOP button and disconnect the power cord from the power source. Reverse any two of the power wires at the main terminal and start again at **step 1**.

6. Approximately 5 seconds after the arbor is started, press the FEED MOTOR START button. The conveyor track should start and run smoothly. Note—*An automatic time delay prevents the conveyor track from starting up until 5 seconds after the main motor has started.*
7. Press both the MAIN MOTOR STOP and the FEED MOTOR STOP buttons to turn the machine off.
8. **Disconnect the machine from the power source.**
9. Install the saw blade by reversing the steps in the “Remove the Blade” subsection on the previous page. Note—*Make sure the blade is NOT making contact with any part of the conveyor track.*



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## Scale Calibration

The distance between the right edge of the blade teeth and the fence face should be equal to the scale reading on the fence rail. The scale can be adjusted back and forth once the two Phillips head screws (**Figure 15**) are loosened.

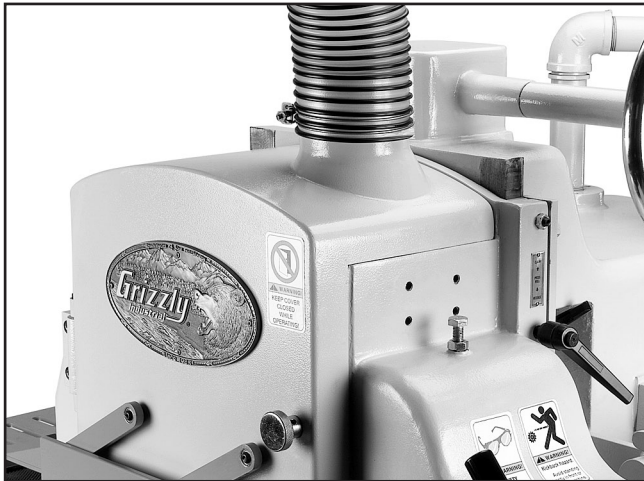


**Figure 15.** Phillips head screws securing the fence scale.



# Dust Collection

An efficient and clean dust collection system is essential to the proper function of the rip saw. Ensuring a healthy work environment is also dependent upon cleaning and maintaining the dust collection system. Clamp a 4" hose from the dust collection system to the dust port (**Figure 16**).



**Figure 16.** Dust collection hook-up.



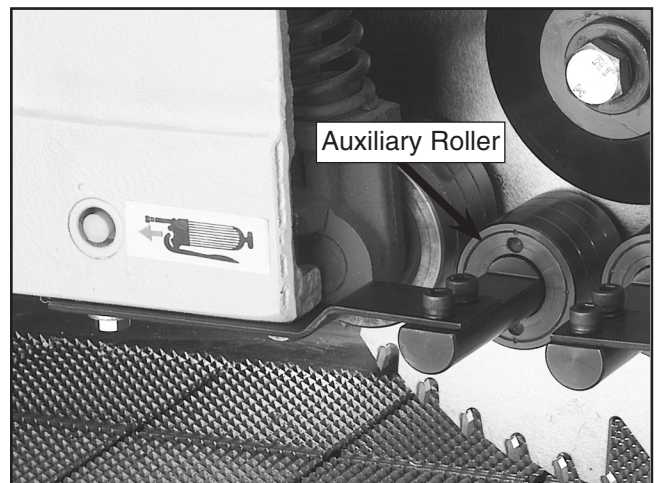
# Auxiliary Rollers

<b>Components and Hardware Needed:</b>	<b>Qty</b>
Auxiliary Roller Brackets (Left) .....	2
Auxiliary Roller Brackets (Right) .....	2
Auxiliary Rollers.....	4
Hardware Bag	
—Cap Screws M6-1.0 x 16 .....	8
—Setscrews M6-1.0 x 30 .....	4
—Lock Washers 6mm .....	8
—Flat Washers 6mm .....	4
—Hex Nuts 6-1.0.....	4

### Tools Needed:

Allen Wrench 3mm .....	1
Allen Wrench 4mm .....	1
Allen Wrench 5mm .....	1
Wrench 10mm .....	1
Wrench 13mm .....	1

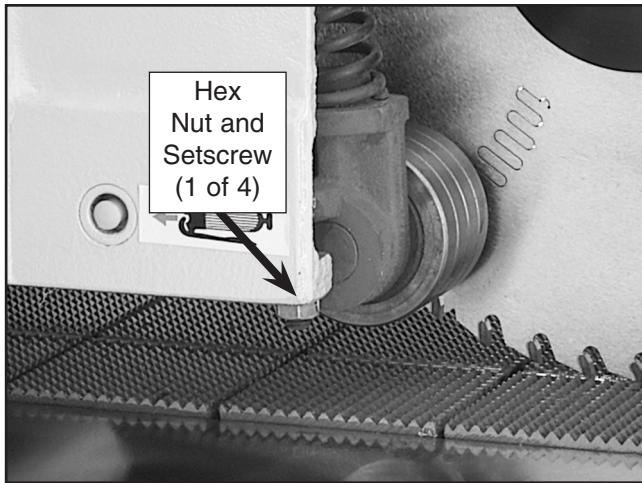
The Model G0524 is supplied with 4 auxiliary rollers (**Figure 17**) that can be attached when rip cutting workpieces shorter than 8". Note—*These auxiliary rollers can be left on the machine when cutting longer boards; however, the maximum thickness cutting capacity of the saw is reduced to 2¼".*



**Figure 17.** Auxiliary roller (1 of 4).

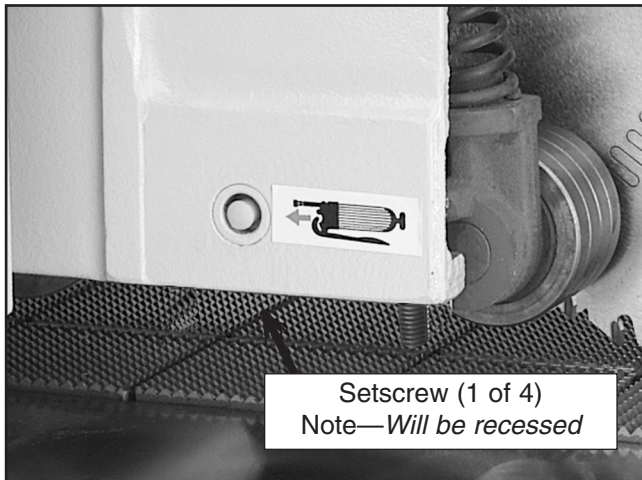
**To install the auxiliary rollers:**

1. Using a 13mm wrench, remove the 4 hex nuts from the setscrews on the underside of the head casting (**Figure 18**).



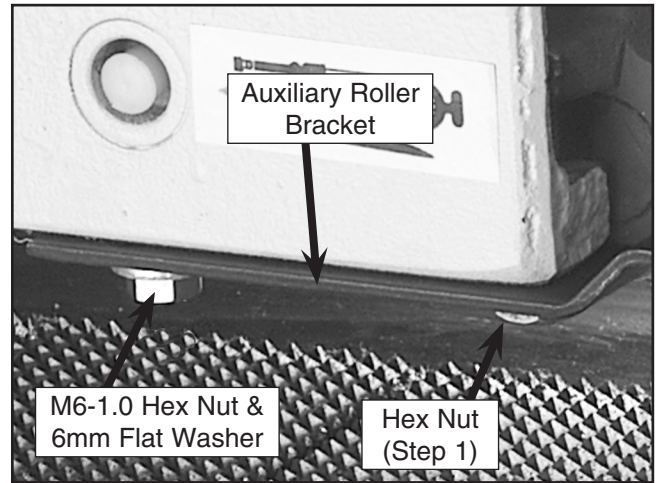
**Figure 18.** Hex nut.

2. Using a 3mm Allen wrench, remove the four M6-1.0 x 10 setscrews from the bottom edge of the head casting and replace with the four M6-1.0 x 30 setscrews (**Figure 19**). Note—*The head of the M6-1.0 x 10 setscrews will be recessed up in the head casting.*



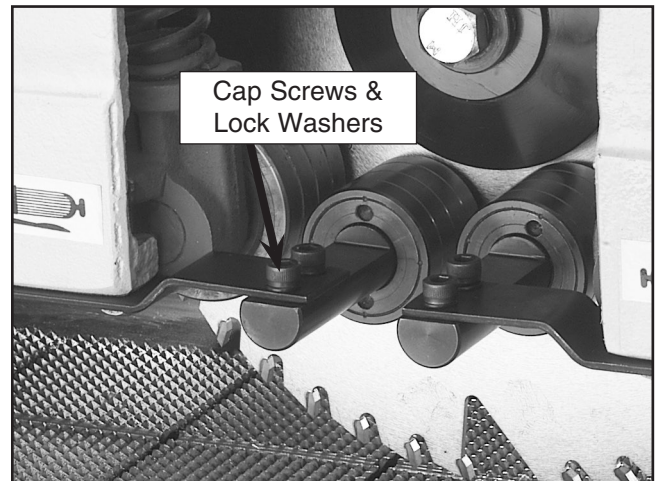
**Figure 19.** Setscrew.

3. Slide the 4 auxiliary roller brackets over the setscrews and secure them with the four M6-1.0 hex nuts and 6mm flat washers, as well as the 4 hex nuts removed in **step 1** (**Figure 20**).



**Figure 20.** Auxiliary roller bracket.

4. Using a 5mm Allen wrench, secure the 4 auxiliary rollers to the brackets with the 8 cap screws and lock washers (**Figure 21**).



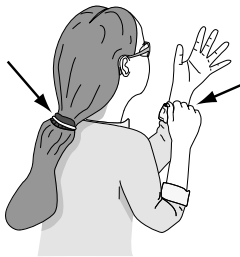
**Figure 21.** Auxiliary roller mounting configuration.



# SECTION 6: OPERATIONS

## **!WARNING**

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



## **!WARNING**

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.

## **NOTICE**

The following section was designed to give instructions on the basic operations of this machine. However, it is in no way comprehensive of all of the machine's applications. **WE STRONGLY RECOMMEND** that you read books, trade magazines, or get formal training to maximize the potential of your machine.

## Safe Operation

Your safety is important. The bullets below are intended to supplement *Section 2: Safety*. But remember, no safety list can be comprehensive of every situation. The operator is ultimately responsible for their own safety, as well as the safety of bystanders. Every cutting operation is uniquely different and may require safety equipment or safety procedures not mentioned in this manual.

**Please follow these tips EVERY time the saw is operated:**

- Stand to the right of the blade line-of-cut when performing a cutting operation.
- Turn the saw *OFF* and allow the blade to come to a complete stop before making any adjustments.
- Make sure the blade guard is installed and that it raises and drops as the workpiece enters and leaves the cutting operation.
- Carefully plan each cutting operation to avoid injuries.



# Adjusting Feed Rate

## **NOTICE**

The conveyor track must be moving when adjusting the feed rate.

Turn the variable speed adjustment knob (**Figure 22**) clockwise to decrease the feed rate and counterclockwise to increase it. The feed rate is variable between 30-112 FPM.



**Figure 22.** Variable speed adjustment knob.

**Determining Ideal Feed Rates**—There are no definitive rules to follow when determining the best feed rate. As a general rule, always start with the slowest feed rate and work up from there. Always perform a test cut with a piece of scrap wood similar to the actual workpiece.



# Rip Cutting

To make a rip cut:

1. Read and understand *Section 1: Safety*, beginning on **page 1**.
2. Before making the very first rip cut, adjust the blade height handwheel to lower the saw blade to within  $\frac{1}{16}$ " of the orange insert located in the conveyor track.
3. **Disconnect the saw from the power source.**
4. Rock the blade back and forth to ensure it is NOT making contact with the conveyor track. Note—*Once the height of the blade is correctly set, DO NOT adjust it until the next time the blade is removed.*
5. Connect the saw to the power source.
6. If not already done, plane the workpiece on both sides and joint one edge.
7. Set the fence to the desired width of cut on the scale.

## **!WARNING**

**DO NOT adjust the height of the pressure roller/head assembly higher than 2 $\frac{1}{4}$ " when the auxiliary rollers are attached. Doing so will cause the blade arbor flange to make contact with the auxiliary rollers.**

8. Adjust the pressure roller height handwheel until the distance between the pressure rollers and the table is approximately  $\frac{1}{8}$ " less than the thickness of the workpiece.
9. Press the MAIN MOTOR START button. The arbor should start and run smoothly.



10. Approximately 5 seconds after the arbor is started, press the FEED MOTOR START button. The conveyor track should start and run smoothly. Note—*An automatic time delay prevents the conveyor track from starting up until 5 seconds after the main motor has started.*

## **!WARNING**

Never attempt to rip a board that does not have one perfectly straight edge. Always guide the straight edge of the board against the rip fence. Failure to do this could result in kickback and serious personal injury.



## **!WARNING**

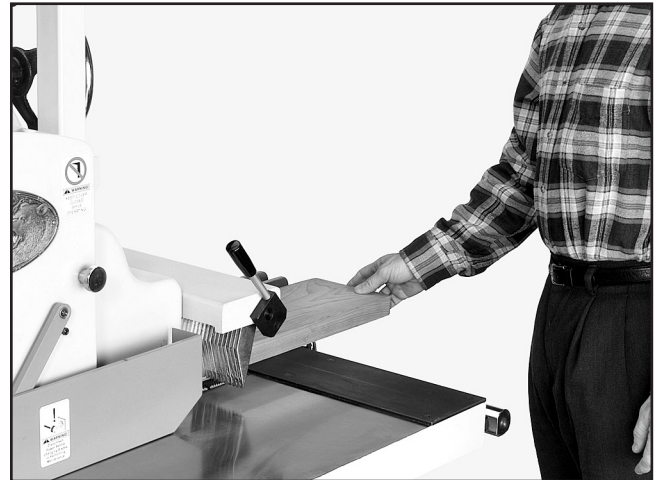
Placing hands or fingers under the workpiece could cause them to be pulled into the rip saw, causing serious personal injury. Do not place hands or fingers under the workpiece.

## **!WARNING**

Never stand directly behind the workpiece while feeding it through the rip saw. Stand to the left or right of the workpiece to avoid serious personal injury in the event of kickback.

12. Push the workpiece into the saw to perform the cutting operation (**Figure 23**).

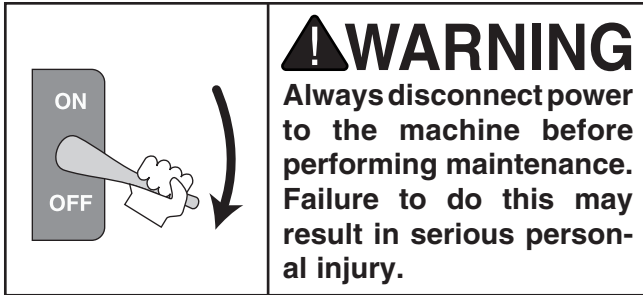
— If the saw is not cutting completely through to the bottom face of the workpiece, the blade needs to be lowered. Only lower the blade just enough to cut completely through the workpiece. Lowering the blade too far could cause the blade to make contact with the conveyor track.



**Figure 23.** Rip cutting operation. The operator is standing to the side of the workpiece to avoid injury in the event of kickback.



# SECTION 7: MAINTENANCE



## Schedule

Check for the following conditions before each use:

- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Leaking or broken lube lines.
- Empty lube reservoir.
- Any other condition that could hamper the safe operation of this machine.

### Monthly:

- Grease Fittings
- V-belts

### After the first 100 hours:

- Gear Box

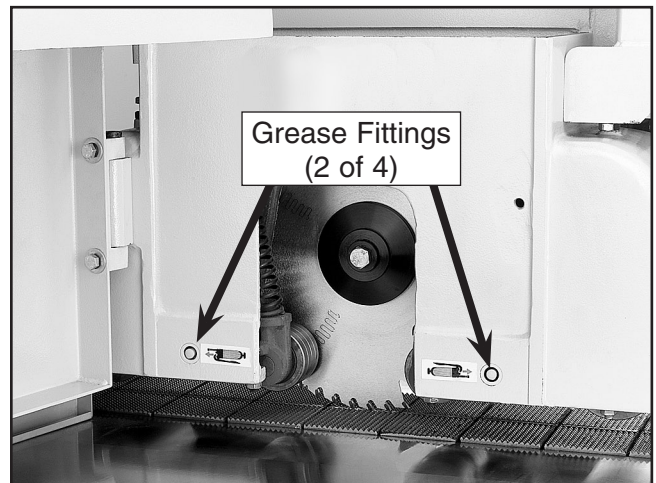
### Every 2500 Hours:

- Gear Box



## Grease Fittings

Lubricate the four grease fittings (**Figure 24**) with a general purpose grease after every month (160 Hours) of regular use.



**Figure 24.** Grease fittings (Additional 2 fittings are on opposite side of head casting).



## Gear Box

The oil inside the gear reducer should be replaced after the first month (160 hours) of regular use. We recommend 90 Wt. gear oil.

After the first oil change, the oil inside the gear reducer should be replaced after every 2500 hours of use. We recommend 90 Wt. gear oil.



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## V-Belts

Inspect V-belts for damage or cracks after every month (160 Hours) of regular use.



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## Bearings

The sealed ball bearings in this machine are permanently sealed and lubricated. There is no need to lubricate them. If the bearing wears out, simply replace it with one ordered from our service department.



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## Lube System

The lube reservoir (**Figure 25**) houses the oil that lubricates the conveyor track. The oil is pumped through a series of plastic tubes at a rate of 3-6 cc every 5 minutes, and onto a brush under the main table. When the oil level in the reservoir becomes low, a switch is triggered that prevents the saw from being operated. If this occurs, fill the reservoir above the “low” line and the saw will operate normally.

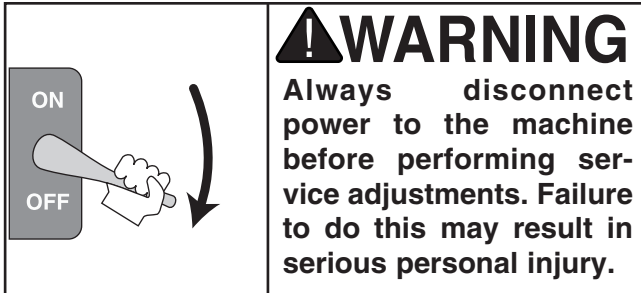


**Figure 25.** Lube reservoir.





# SECTION 8: SERVICE ADJUSTMENTS



## About Service

This section is designed to help the operator with adjustments that were made at the factory and that might also need to be made during the life of the machine.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If any adjustments arise that are not described in this manual, then feel free to call the Grizzly Service Department at (570) 546-9663.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.

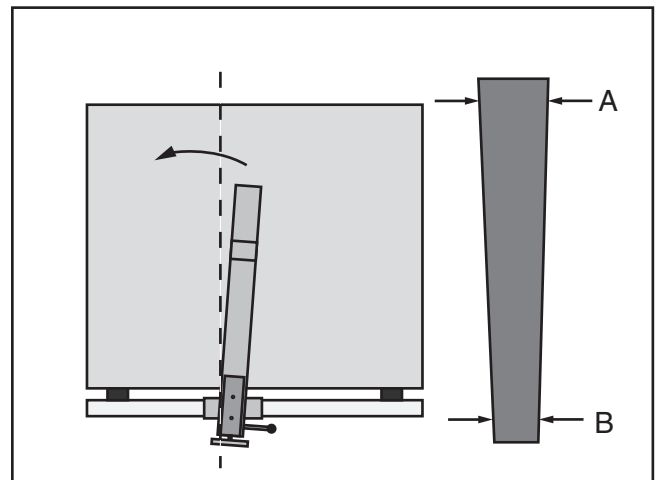


## Fence Alignment

If the face of the fence is not parallel to the saw blade (cut line), the resulting rip cut will yield a workpiece that is wider at one end or the other.

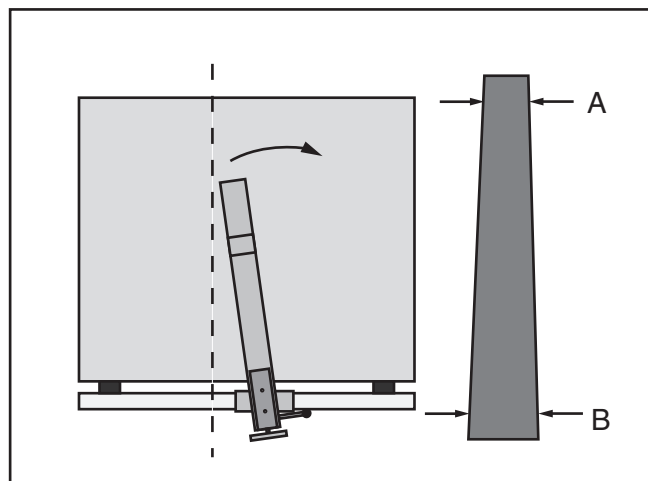
**To adjust the fence alignment:**

1. Rip cut a scrap workpiece.
2. Measure the width at each end of a workpiece that has been cut on the rip saw.
  - If end A is wider than end B, then the tip of the fence needs to be adjusted to the left to make the fence parallel to the blade (**Figure 26**).



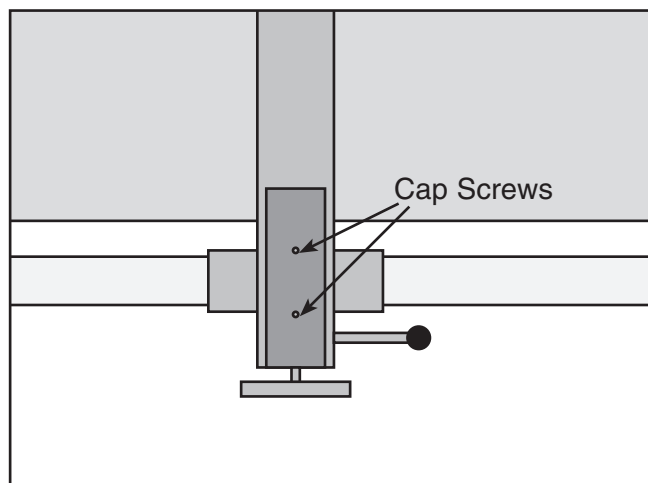
**Figure 26.** Adjusting the fence to the left.

- If end B is wider than end A, then the tip of the fence needs to be adjusted to the right to make the fence parallel to the blade (Figure 27).



**Figure 27.** Adjusting the fence to the right.

3. Loosen the cap screws (Figure 28) on the top of the fence to allow adjustment of the fence. Retighten when complete.



**Figure 28.** Cap screws to loosen fence.

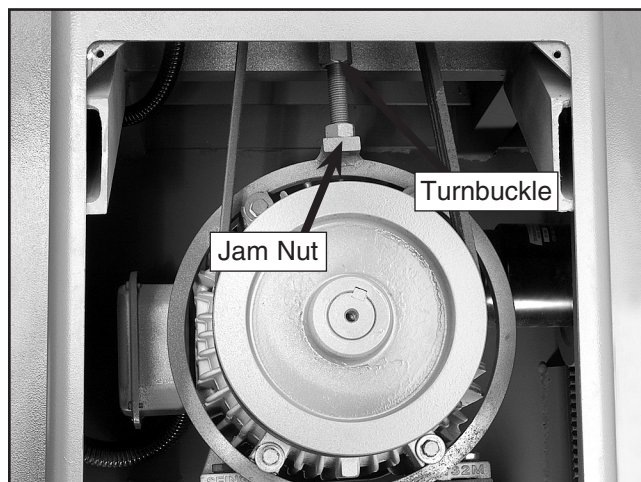
4. Repeat step 1 to verify that the adjustments are correct.



## V-Belt Tension

To adjust the main motor V-belt tension:

1. Disconnect the saw from the power source!
2. Remove the side access panel to reveal the adjustment mechanism.
3. Loosen the jam nut (Figure 29).

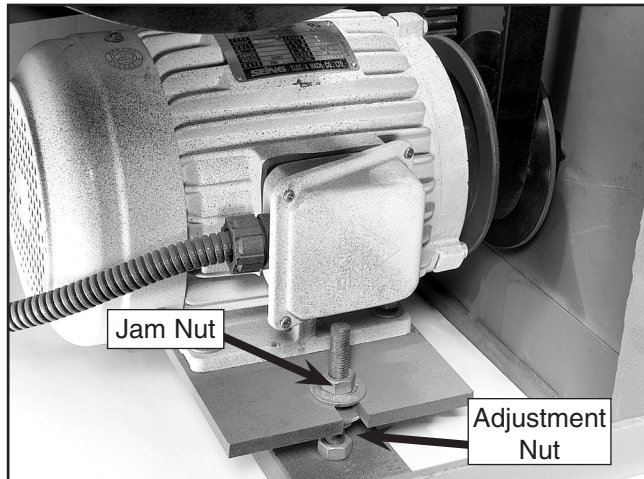


**Figure 29.** Arbor motor V-belt adjustment.

4. Adjust the turnbuckle to increase or decrease the V-belt tension. Note—Turning the turnbuckle clockwise lowers the tension and counterclockwise increases it.
5. Retighten the jam nut when the V-belt has been tensioned correctly and re-install the side access panel.

To adjust the feed motor V-belt tension:

1. **Disconnect the saw from the power source!**
2. Remove the side access panel to reveal the adjustment mechanism.
3. Loosen the jam nut (**Figure 30**).



**Figure 30.** Feed motor V-belt adjustment.

4. Raise or lower the adjustment nut to change the V-belt tension. Note—*Raise the adjustment nut to decrease the tension and lower it to increase the tension.*
5. Retighten the jam nut when the V-belt has been tensioned correctly and re-install the side access panel.



## Fence Ride Height

To adjust the ride height of the fence:

Adjust the setscrew (**Figure 31**) to raise and lower the ride height of the fence. Note—*The fence could scratch the cast iron table surface if the ride height is set too low.*



**Figure 31.** Fence ride height adjustment.



# Pressure Rollers

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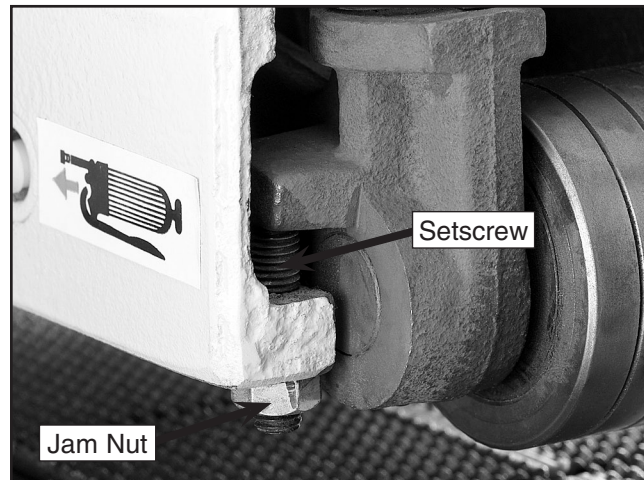
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The pressure rollers must all be the same distance away from the table surface (conveyor track).

## To adjust the pressure rollers:

1. **Disconnect the saw from the power source!**
2. Using the blade height handwheel, raise the bottom edge of the blade above the bottom-dead-center of the pressure rollers.
3. Using the pressure roller height handwheel, raise the head of the saw high enough to allow a flat board to be placed under all the the pressure rollers.
4. Slowly lower the head.
  - If the pressure rollers make contact with the board at the same time, they are adjusted correctly.
  - If the pressure rollers do not make contact with the board at the same time, they need to be adjusted so they do. Continue with the next step.

5. Each pressure roller can be independently adjusted by loosening the jam nut and turning the small setscrew (**Figure 32**). Note— *Turning the setscrew clockwise, as viewed from the top, lowers the pressure roller; counterclockwise raises the pressure roller.*



**Figure 32.** Setscrew for height adjustment.

6. Once the pressure rollers are adjusted correctly, retighten the jam nuts.





# Gibs

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The head of the saw slides up and down on gibs. Over time, the gibs may need to be tightened to compensate for wear. Loosen the jam nuts and adjust the setscrews to reduce the “play” along the gibs (**Figure 33**). Always make small adjustments to the setscrews, starting with  $\frac{1}{4}$  turn increments. When adjusted correctly, tighten the jam nuts and make sure the head slides up and down smoothly.



**Figure 33.** Gib adjustment setscrews.



# Service Log

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Date	Approximate Hours Of Use	Service Performed



# SECTION 9: REFERENCE INFO

## General

This section contains the following subsections for the Model G0524: aftermarket accessories, data sheets, parts diagrams and lists, troubleshooting, wiring diagrams, and warranty/return information.

If you need parts or help in assembling your machine, or if you need operational information, call the service department at (570) 546-9663. Trained service technicians will be glad to help you.

If you have any comments regarding this manual, please write to Grizzly at the address below:

Grizzly Industrial, Inc.  
% Technical Documentation  
P.O. Box 2069  
Bellingham, WA 98227-2069

We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the Service Department at the location listed below.

Grizzly Industrial, Inc.  
1203 Lycoming Mall Circle  
Muncy, PA 17756  
Phone: (570) 546-9663  
Fax: (800) 438-5901  
E-Mail: [techsupport@grizzly.com](mailto:techsupport@grizzly.com)  
Web Site: <http://www.grizzly.com>.



## Aftermarket Accessories

### OxiSolv® Blade & Bit Cleaner - G1955

Used to clean the gummy pitch and residue from saw blades and router bits, this high quality cleaner will make blades and bits last longer while improving cutting action.



Figure 34. G1955 OxiSolv®.

### SLIPIT® Lubricant - G5562 & G5563

Used on cast iron table surfaces and other unpainted metal surfaces to reduce rust and corrosion. This product is perfect for keeping tools clean, especially during long-term storage.



Figure 35. G5562 & G5563 SLIPIT.

### Laser Guide with Arm - H5749

Improve rip cutting accuracy, work more efficiently, and increase yields with the optional Grizzly H5749 Laser Guide. This bolt-on accessory is perfect for production shop looking to make the most of their Grizzly G0524 Rip Saw.

Inventory	Qty
• Steel Arm.....	1
• Laser Bracket .....	1
• Laser Clamp .....	1
• Laser.....	1
• Power Box .....	1
• Cap Screws M8-1.25 x 25.....	4
• Flat Washers 8mm .....	4
• Lock Washers 8mm.....	4
• Cap Screws M6-1 x 16.....	2
• Flat Washers 6mm .....	2
• Cap Screws M6-1 x 35.....	2
• Phillips Head Screws M5-.8 x 8 .....	2

### To install the laser guide on the Model G0524 Rip Saw:

1. **Disconnect the Model G0524 Rip Saw from the power source!**
2. Attach the steel arm to the head casting with the (4) M8-1.25 x 25 cap screws, (4) 8mm flat washers, and (4) M8 lock washers. Note—*The mounting location and drill pattern for the steel arm are shown on page 46. The holes must be drilled and tapped to accept M8-1.25 threads.*
3. Mount the laser bracket to the top of the steel arm with the (2) M6-1 x 16 cap screws and (2) 6mm flat washers.
4. Place the laser clamp around the laser and secure the assembly to the laser bracket with the (2) M6-1 x 35 cap screws.
5. Attach the black power box to the rip saw with the (2) M5-8 x 8 Phillips head screws. Note—*Make sure the loose end of the green ground wire is secured between the head of the Phillips screw and the black power box.*
6. Route the power wires from the power box through the side of the saw base and into the electrical panel compartment.

7. Connect the R1 and T1 power wires to their respective R1 and T1 locations on the main terminal at the electrical panel.
8. Feed the laser power wire through the access holes on the steel arm, and plug the power wire into the back of the power box.
9. Cut a board, turn the saw *OFF*, place the board against the fence, and finally, adjust the laser beam along the freshly cut edge.

**! WARNING**  
**DO NOT look into the end of the laser.**  
**Serious eye damage will occur.**

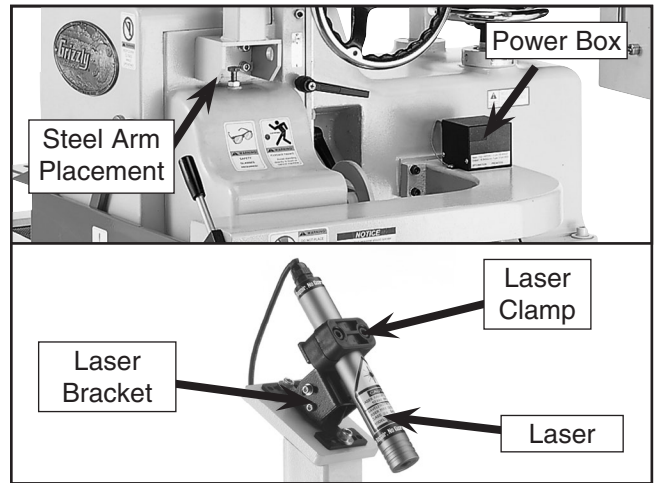


Figure 1. Model H5749 Laser Guide.

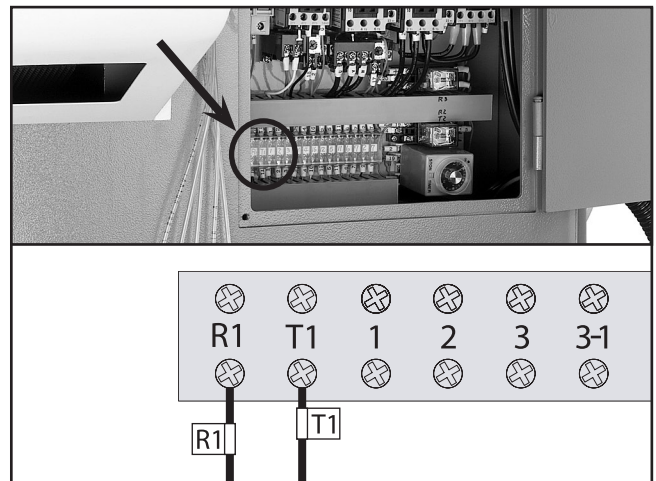


Figure 2. Electrical wiring.



# MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

## MODEL G0524 RIP SAW

Design Type ..... Floor Model

### Capacities:

Maximum Blade Diameter ..... 10"-12"  
 Arbor Size ..... 1"  
 Spindle Speed ..... 4500 RPM  
 Maximum Cutting Height ..... 3<sup>7</sup>/<sub>8</sub>"  
 Maximum Cutting Height W/Auxiliary Rollers ..... 2<sup>1</sup>/<sub>4</sub>"  
 Maximum Width of Cut ..... 18"  
 Maximum Distance From Blade to Column ..... 18"  
 Minimum Cutting Length ..... 8" with Auxiliary Hold-Down Roller Kit  
 Feed Speed ..... 30-112 FPM

### Overall Dimensions:

Table Height ..... 32<sup>1</sup>/<sub>4</sub>"  
 Table Size ..... 53"W x 37"D  
 Table Size with Fence ..... 56"W x 37"D  
 Crate Size ..... 57"W x 45<sup>1</sup>/<sub>4</sub>"D x 67"  
 Footprint ..... 35" x 30<sup>1</sup>/<sub>8</sub>"  
 Net Weight ..... 1980 lbs.  
 Shipping Weight ..... 2243 lbs.

### Construction:

Table ..... Precision Machined Steel  
 Cabinet ..... Steel  
 Rails ..... Hardened & Precision Ground Cast Iron  
 Anti-Kickback Fingers ..... Steel  
 Spindle Bearings ..... Shielded & Permanently Lubricated  
 Blade Guard ..... Pre-Formed Steel  
 Fence ..... Precision Machined Cast Iron Body

### Motors:

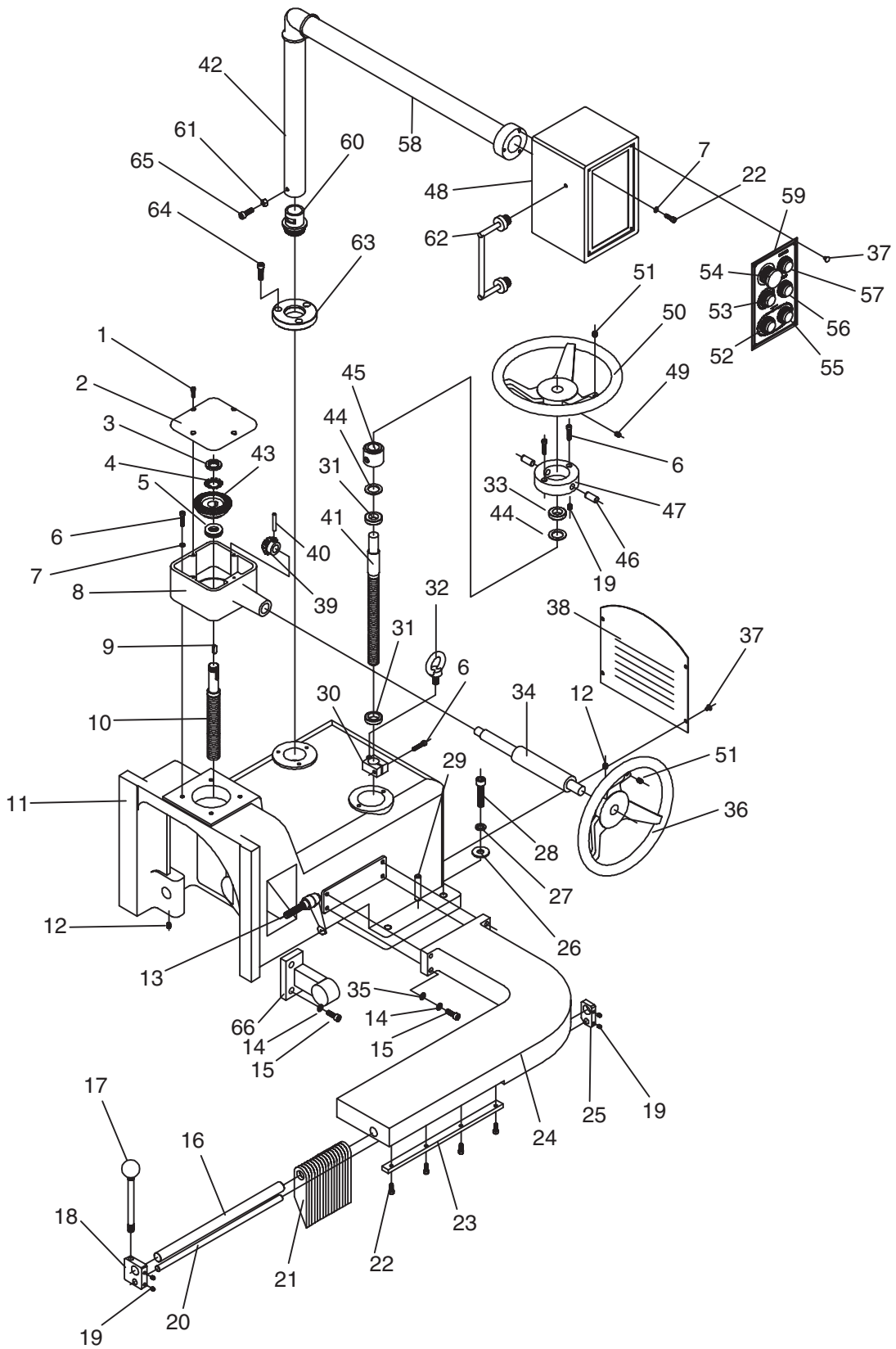
Type ..... TEFC Induction  
 Horsepower ..... 15 HP Main Motor; 2 HP Feed Motor  
 Phase-Type / Voltage ..... 3-Phase, 220/440V  
 Pre-Wired ..... 220V  
 Amps ..... 37/18<sup>1</sup>/<sub>2</sub> Main Motor; 6/3 Feed Motor  
 RPM ..... 1725 RPM Main Motor; 1725 RPM Feed Motor  
 Switch ..... Magnetic with Thermal Overload Protection  
 Power Transfer ..... V-Belt Drive  
 Bearings ..... Shielded & Permanently Lubricated Ball

### Features:

..... Automatic Conveyor Track Lubrication System  
 ..... Double Row of Anti-Kickback Fingers  
 ..... High-Efficiency 4" Dust Port  
 ..... 4 Heavy-Duty Pressure rollers  
 ..... Convenient & Easy-To-Reach Control Panel

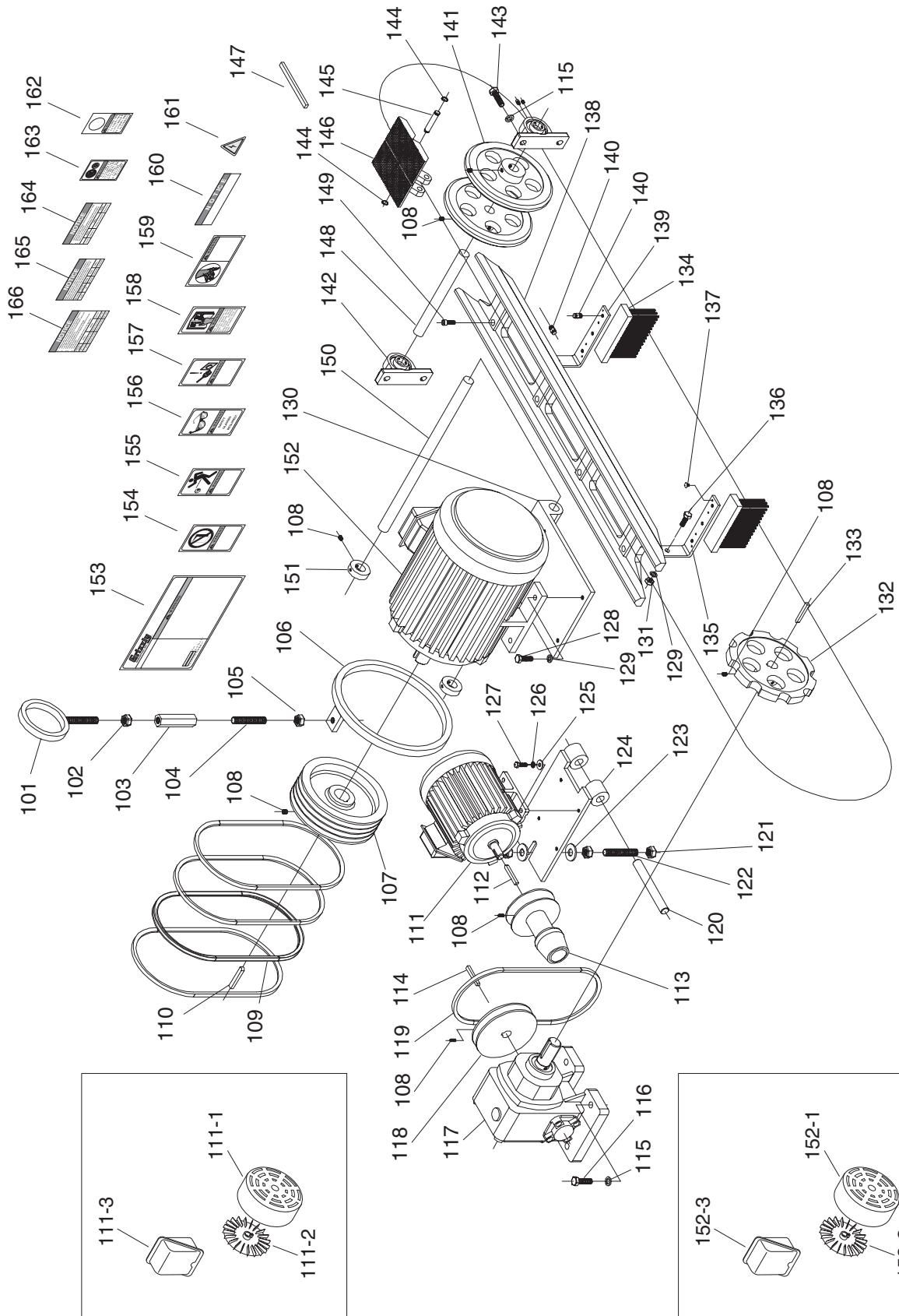
*Specifications, while deemed accurate, are not guaranteed.*

11/2003



REF	PART #	DESCRIPTION
1	PSB24M	CAP SCREW M5-.8 X 16
2	P0524002	COVER, GEAR BOX
3	P0524003	SPANNER LOCK NUT M20-1.0
4	PTLW09M	EXT TOOTH WASHER 20MM
5	P51104	THRUST BEARING 51104
6	PSB07M	CAP SCREW M6-1 X 30
7	PLW03M	LOCK WASHER 6MM
8	P0524008	GEAR BOX
9	PK82M	KEY 7 X 7 X 18
10	P0524010	LEAD SCREW
11	P0524011	LOCK SEAT
12	PSS06M	SET SCREW M8-1.25 X 16
13	P0524013	HANDLE
14	PLW04M	LOCK WASHER 8MM
15	PSB40M	CAP SCREW M8-1.25 X 35
16	P0524016	SHAFT
17	P0524017	KNOB LEVER M10-1.5 X 135
18	P0524018	BLOCK
19	PSS01M	SET SCREW M6-1 X 10
20	P0524020	SHAFT
21	P0524021	ANTI-KICKBACK FINGER
22	PSB01M	CAP SCREW M6-1 X 16
23	P0524023	FIXED PLATE
24	P0524024	SEAT
25	P0524025	BLOCK
26	PW06M	FLAT WASHER 12MM
27	PLW05M	LOCK WASHER 12MM
28	PSB119M	CAP SCREW M12-1.75 X 55
29	P0524029	SPECIAL TAPER PIN
30	P0524030	LOCKING STOPPER
31	P0524031	SPECIAL RING
32	P0524032	LIFTING EYE BOLT M12-1.75 X 22
33	P0524033	SPECIAL RING
34	P0524034	SHAFT

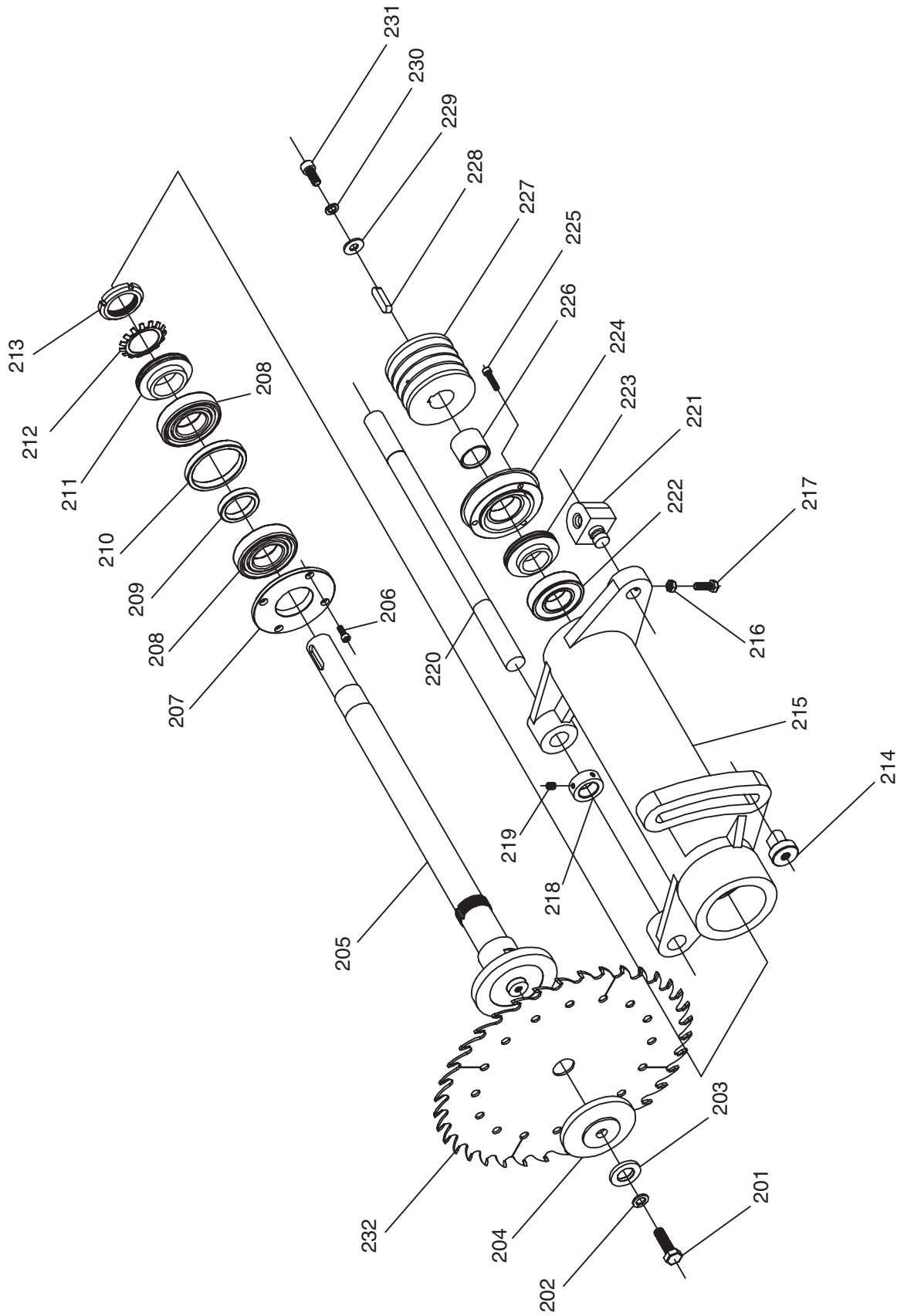
REF	PART #	DESCRIPTION
35	PW01M	FLAT WASHER 8MM
36	P0524036	HANDWHEEL
37	PS05M	PHLP HD SCR M5-.8 X 8
38	P0524038	COVER
39	P0524039	BEVEL GEAR, SMALL
40	PRP49M	ROLL PIN 5 X 25
41	P0524041	LEAD SCREW
42	P0524042	ARM, CONTROL BOX
43	P0524043	BEVEL GEAR, BIG
44	P0524044	SPACER
45	P0524045	BUSHING
46	P0524046	SPECIAL PIN
47	P0524047	COVER
48	P0524048	SWITCH BOX
49	PSS16M	SET SCREW M8-1.25 X 10
50	P0524050	HANDWHEEL
51	PSS15	SET SCREW 3/8-16 X 3/8
52	P0524052	INFEEED BUTTON, ON
53	P0524052	SAW BLADE BUTTON, ON
54	P0524054	EMERGENCY BUTTON
55	P0524055	INFEEED BUTTON, OFF
56	P0524055	SAW BLADE BUTTON, OFF
57	P0524057	ELECTRIC POWER BUTTON
58	P0524058	ARM, CONTROL BOX
59	P0524059	PANEL
60	P0524060	ROTATION SEAT
61	PN03M	HEX NUT M8-1.25
62	P0524062	HANDLE
63	P0524063	ROTATION SEAT
64	PSB14M	CAP SCREW M8-1.25 X 20
65	PSS09M	SET SCREW M8-1.25 X 20
66	P0524066	BRACKET
67	P0524067	440V CONVERSION KIT





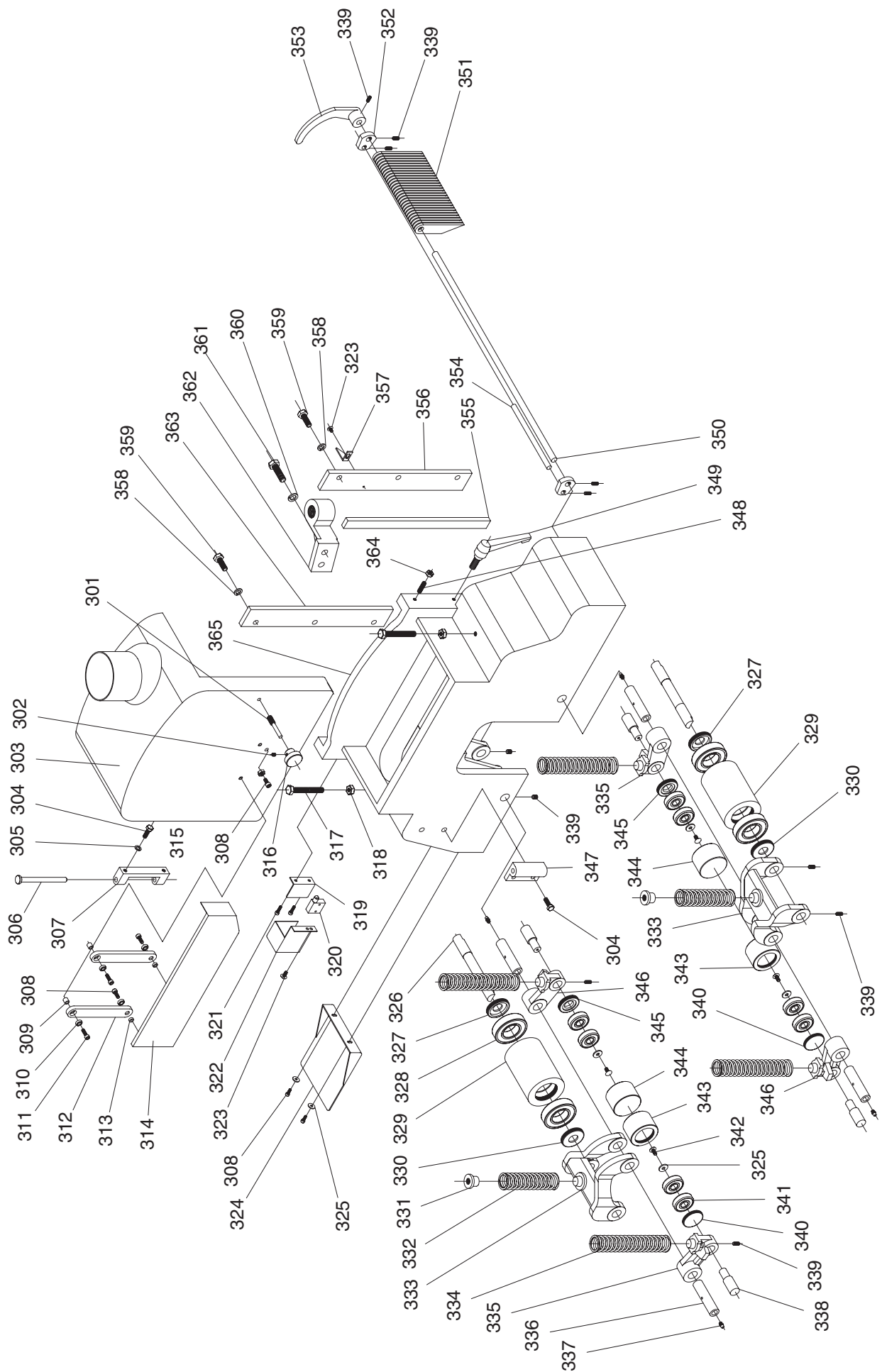
REF	PART #	DESCRIPTION
101	P0524101	SPEC. EYE-BOLT M16-2 X 90LH
102	P0524102	HEX NUT M16-2LH
103	P0524103	SPECIAL NUT M16-2 LH/RH
104	P0524104	SPECIAL BOLT M16-2 X 110
105	PN13M	HEX NUT M16-2.0
106	P0524106	ADJUSTING RING
107	P0524107	PULLEY
108	PSS06M	SET SCREW M8-1.25 X 16
109	PVA55	V-BELT A-55 4L550
110	PK83M	KEY 10 X 8 X 70
111	P0524111	MOTOR 2 HP
111-1	P0524111-1	MOTOR COVER 2 HP
111-2	P0524111-2	MOTOR FAN 2 HP
111-3	P0524111-3	MOTOR WIRE COVER 2 HP
112	PK41M	KEY 8 X 8 X 40
113	P0524113	REDUCER PULLEY
114	PK62M	KEY 7 X 7 X 45
115	PLW05M	LOCK WASHER 12MM
116	PB35M	HEX BOLT M12-1.75 X 40
117	P0524117	REDUCER, WORM GEAR
118	P0524118	REDUCER PULLEY
119	P0524119	COG TOOTH BELT 1922V30-22
120	P0524120	SHAFT
121	PN09M	HEX NUT M12-1.75
122	P0524122	STUD BOLT M12-1.75 X 100
123	PW06M	FLAT WASHER 12MM
124	P0524124	MOTOR SEAT
125	PW06M	FLAT WASHER 12MM
126	PLW04M	LOCK WASHER 8MM
127	PB07M	HEX BOLT M8-1.25 X 25
128	PB14M	HEX BOLT M10-1.5 X 35
129	PLW06M	LOCK WASHER 10MM
130	P0524130	MOTOR SEAT
131	PN02M	HEX NUT M10-1.5
132	P0524132	SPROCKET (10T)
133	PK84M	KEY 10 X 8 X 30
134	P0524134	BRUSH

REF	PART #	DESCRIPTION
135	P0524135	BRACE
136	PB01M	HEX BOLT M10-1.5 X 30
137	PS21	PHLP HD SCR #8 X 3/4"
138	P0524138	RAIL BODY
139	P0524139	BRACE
140	P0524140	OIL NOZZLE 1/8"PT X 4MM
141	P0524141	IDLE WHEEL
142	P0524142	BALL BEARING ASSEMBLY
143	PB27M	HEX BOLT M12-1.75 X 30
144	PR03M	EXT RETAINING RING 12MM
145	P0524145	SHAFT
146	P0524146	CATERPILLAR BLOCK
146-1	P0524146-1	CAT. BLOCK FITTED BAKELITE
147	P0524147	BAKELITE
148	P0524148	SHAFT
149	PSB31M	CAP SCREW M8-1.25 X 25
150	P0524150	SHAFT
151	P0524151	SPACER
152	P0524152	MOTOR 15 HP
152-1	P0524152-1	MOTOR COVER 15 HP
152-2	P0524152-2	MOTOR FAN 15 HP
152-3	P0524152-3	MOTOR WIRE COVER 15 HP
153	P0524153	MACHINE ID LABEL
154	P0524154	KEEP COVER CLOSED LABEL
155	P0524155	KICKBACK LABEL
156	PLABEL-11	SAFETY GLASSES LABEL
157	P0524157	UNPLUG LABEL 220V
158	PLABEL-12	READ MANUAL LABEL
159	P0524159	INFEED HAND LABEL
160	P0524160	TRAINING LABEL
161	PLABEL-14	ELECTRICITY LABEL
162	P0524162	HANGING BUTTON LABEL
163	P0524163	ARBOR ROTATION LABEL
164	P0524164	GREASE FITTING LABEL
165	P0524165	LUBRICANT OIL LABEL
166	P0524166	GEAR OIL LABEL



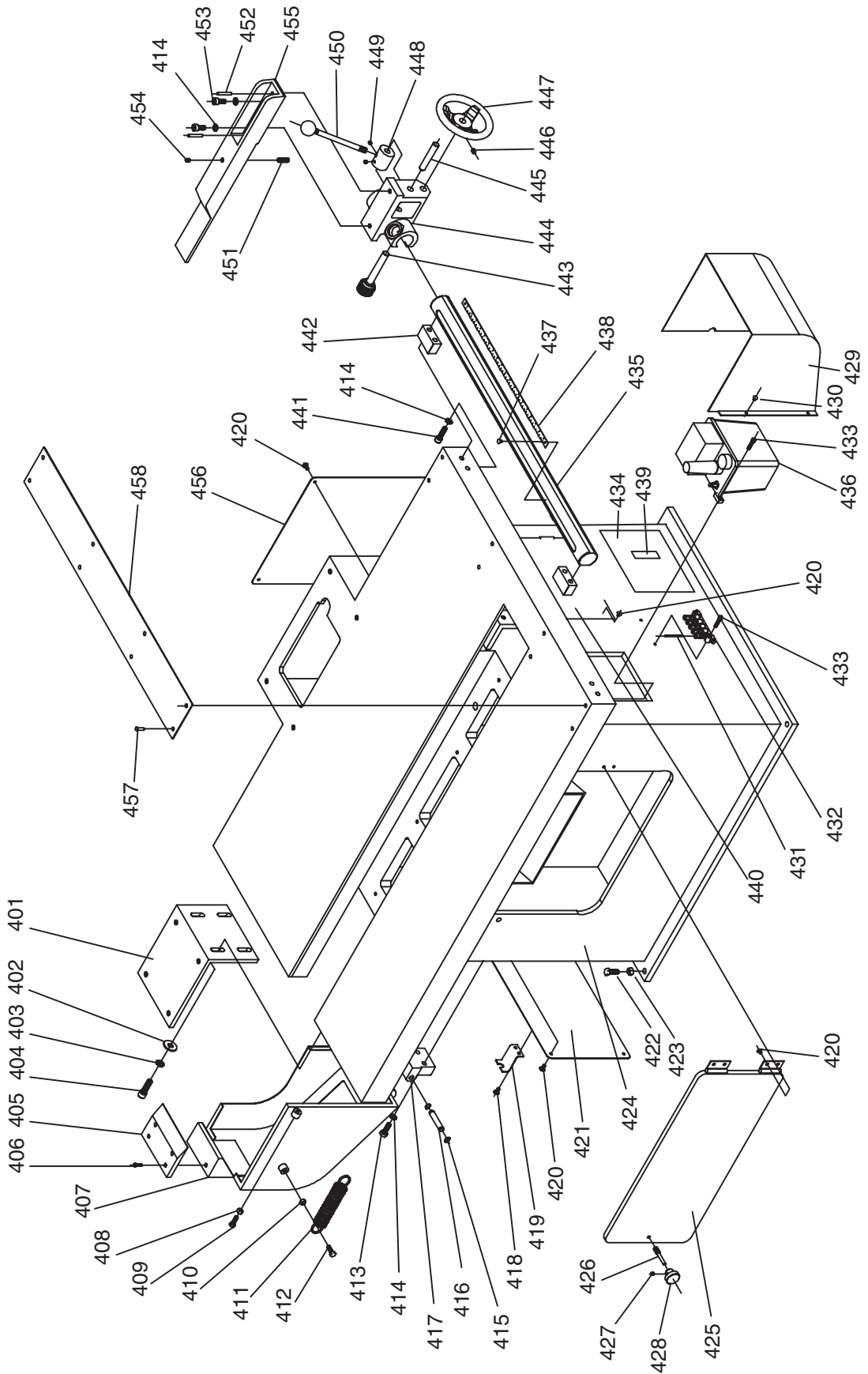
REF	PART #	DESCRIPTION
201	PB35M	HEX BOLT M12-1.75 X 40
202	PLW05M	LOCK WASHER 12MM
203	P0524203	SPECIAL WASHER 12 X 30 X 5MM
204	P0524204	PRESS PLATE
205	P0524205	MAIN SPINDLE
206	PSB01M	CAP SCREW M6-1 X 16
207	P0524207	COVER, FRONT
208	P7208	BALL BEARING 7208
209	P0524209	RING
210	P0524210	RING
211	P0524211	STOPPER, FRONT
212	PTLW10M	EXT TOOTH WASHER 40MM
213	P0524213	SPANNER LOCK NUT M40-1.5LH
214	P0524214	SPECIAL NUT M12-1.75
215	P0524215	SPINDLE SHAFT BOX
216	PN03M	HEX NUT M8-1.25

REF	PART #	DESCRIPTION
217	PB20M	HEX BOLT M8-1.25 X 35
218	P0524218	LOCK COLLAR
219	PSS16M	SET SCREW M8-1.25 X 10
220	P0524220	SHAFT
221	P0524221	SPECIAL NUT TW22-P5
222	P6207	BALL BEARING 6207ZZ
223	P0524223	STOPPER, REAR
224	P0524224	COVER, SPINDLE
225	PSB07M	CAP SCREW M6-1 X 30
226	P0524226	SPACER
227	P0524227	PULLEY, SPINDLE
228	PK85M	KEY 10 X 8 X 40
229	PW04M	FLAT WASHER 10MM
230	PLW06M	LOCK WASHER 10MM
231	PSB64M	CAP SCREW M10-1.5 X 25
232	P0524232	SAW BLADE 12" X 48T X 4W



REF	PART #	DESCRIPTION
301	P0524301	KNOB SCREW M10-1.5 X 20
302	PSS02M	SET SCREW M6-1 X 6
303	P0524303	CHIP FUNNEL
304	PS32M	PHLP HD SCR M8-1.25 X 25
305	PLW04M	LOCK WASHER 8MM
306	P0524306	SHAFT
307	P0524307	HINGE (BIG)
308	PS11M	PHLP HD SCR M6-1 X 16
309	P0524309	BUSHING 6 X 10 X 10T
310	P696	BALL BEARING 696
311	PS47M	PHLP HD SCR M6-1 X 25
312	P0524312	WOBBLE ARM
313	P0524313	BUSHING 6 X 10 X 6T
314	P0524314	SIDE GUARD
315	PN01M	HEX NUT M6-1
316	P0524316	STEEL KNOB (FEMALE 7MM)
317	PB13M	HEX BOLT M10-1.5 X 80
318	PN02M	HEX NUT M10-1.5
319	P0524319	BRACKET
320	P0524320	LIMIT SWITCH
321	PS08M	PHLP HD SCR M5-.8 X 12
322	P0524322	COVER
323	PS05M	PHLP HD SCR M5-.8 X 8
324	P0524324	BACK SAFETY GUARD
325	PW03M	FLAT WASHER 6MM
326	P0524326	SHAFT
327	P0524327	BEARING COVER, RIGHT
328	P6204	BALL BEARING 6204ZZ
329	P0524329	ROLLER
330	P0524330	BEARING COVER, LEFT
331	P0524331	SPRING
332	P0524332	SPRING SEAT
333	P0524333	ARM

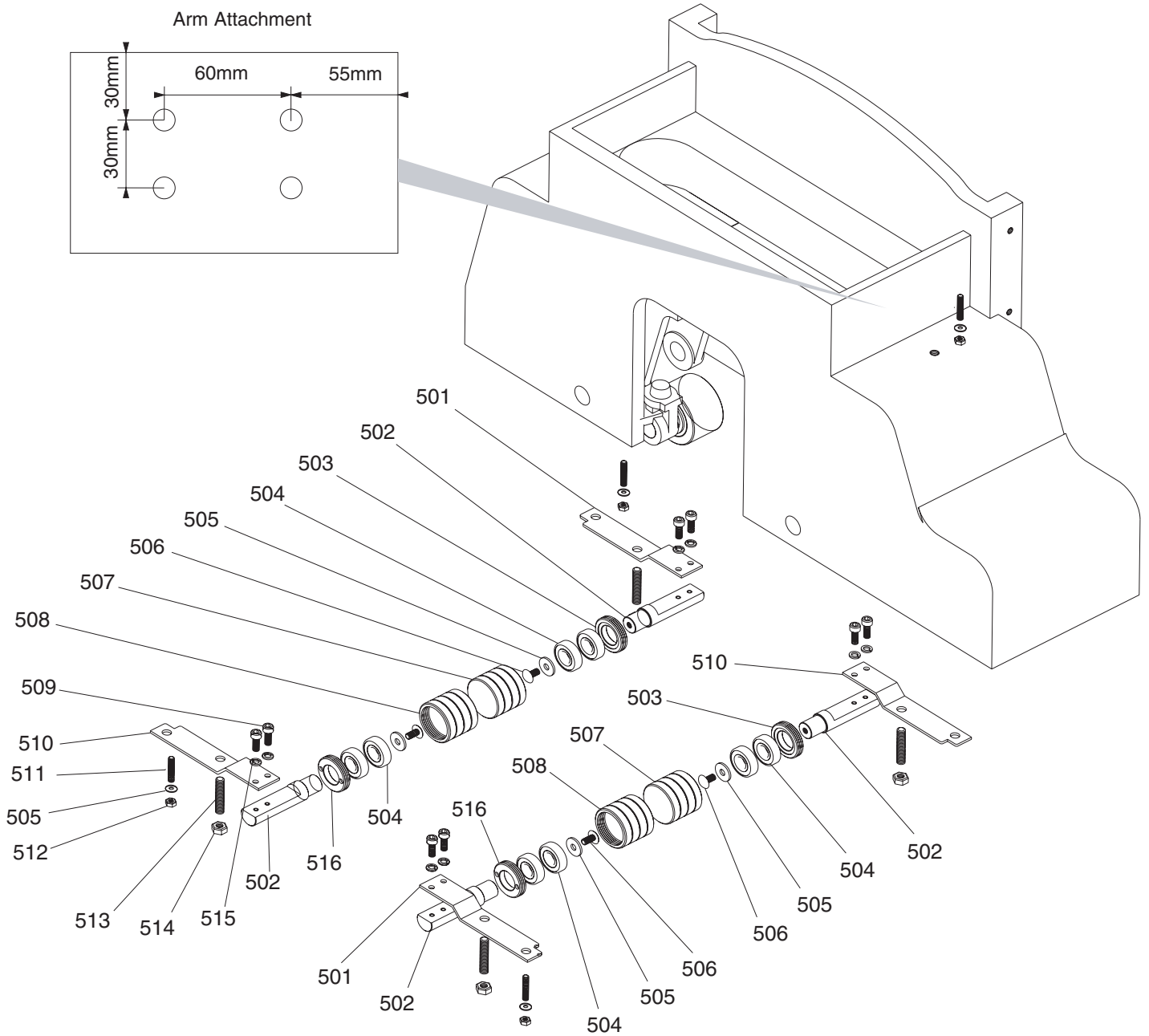
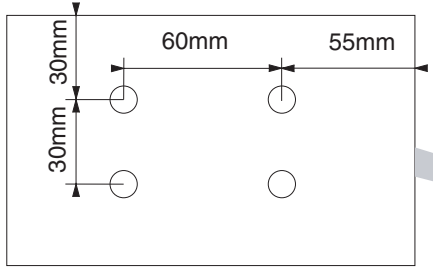
REF	PART #	DESCRIPTION
334	P0524334	SPRING
335	P0524335	ARM
336	P0524336	SHAFT
337	P0524337	GREASE FITTING M6-1 X 6
338	P0524338	SHAFT
339	PSS01M	SET SCREW M6-1 X 10
340	P0524340	BEARING COVER, LEFT
341	P6302	BALL BEARING 6302
342	PS14M	PHLP HD SCR M6-1 X 12
343	P0524343	ROLLER, LEFT
344	P0524344	ROLLER, RIGHT
345	P0524345	BEARING COVER, RIGHT
346	P0524346	ARM, LEFT
347	P0524347	HINGE (SMALL)
348	PSS19M	SET SCREW M8-1.25 X 30
349	P0524349	HANDLE M12-30
350	P0524350	SHAFT
351	P0524351	FINGERS
352	P0524352	BLOCK
353	P0524353	BRACKET
354	P0524354	SHAFT
355	P0524355	SLIDE PLATE
356	P0524356	LOCK BAR
357	P0524357	NEEDLE
358	PLW06M	LOCK WASHER 10MM
359	PB01M	HEX BOLT M10-1.5 X 30
360	PLW05M	LOCK WASHER 12MM
361	PB35M	HEX BOLT M12-1.75 X 40
362	P0524362	BRACKET
363	P0524363	LOCK BAR
364	PN03M	HEX NUT M8-1.25
365	P0524365	ROLLER SEAT
366	G8589	LARGE CAST LOGO



REF	PART #	DESCRIPTION
401	P0524401	BRACKET
402	PW06M	FLAT WASHER 12MM
403	PLW05M	LOCK WASHER 12MM
404	PSB92M	CAP SCREW M12-1.75 X 40
405	P0524405	COVER PLATE
406	PSB24M	CAP SCREW M5-.8 X 16
407	P0524407	COVER
408	PN03M	HEX NUT M8-1.25
409	PB20M	HEX BOLT M8-1.25 X 35
410	PN08M	HEX NUT M10-1.25
411	P0524411	SPRING
412	PSB89M	CAP SCREW M10-1.25 X 35
413	PB116M	HEX BOLT M10-1.5 X 45
414	PLW06M	LOCK WASHER 10MM
415	PR03M	EXT RETAINING RING 12MM
416	P0524416	SHAFT
417	P0524417	BRACKET
418	PSB04M	CAP SCREW M6-1 X 10
419	P0524419	BRACKET
420	PS14M	PHLP HD SCR M6-1 X 12
421	P0524421	COVER
422	PB114M	HEX BOLT M10-1.5 X 45
423	PN05M	HEX NUT M16-1.5
424	P0524424	STAND
425	P0524425	COVER
426	P0524426	LOCK SCREW
427	PSS02M	SET SCREW M6-1 X 6
428	P0524428	STEEL KNOB (FEMALE 7MM)
429	P0524429	COVER

REF	PART #	DESCRIPTION
430	PS05M	PHLP HD SCR M5-.8 X 8
431	P0524431	OIL TUBE
432	P0524432	CONTACTOR, LUBRICATION
433	PSB02M	CAP SCREW M6-1 X 20
434	P0524434	COVER
435	P0524435	COLUMN, GEAR
436	P0524436	LUBRICATOR
437	PS79M	PHLP HD SCR M3-0.5 X 8
438	P0524438	SCALE 480MM
439	P0524439	ACRYLIC PIECE
440	P0524440	COVER
441	PSB71M	CAP SCREW M10-1.5 X 60
442	P0524442	BRACKET
443	P0524443	GEAR
444	P0524444	GEAR BOX
445	P0524445	SHAFT
446	PSS16M	SET SCREW M8-1.25 X 10
447	P0524447	HANDWHEEL
448	P0524448	SETTING BLOCK
449	PSS01M	SET SCREW M6-1 X 10
450	P0524450	KNOB LEVER M12-1.75 X 140
451	P0524451	SPECIAL SCREW M10-1.5 X 28
452	P0524452	TAPER PIN #7 X 1-1/2"
453	PSB89M	CAP SCREW M10-1.25 X 35
454	PSS75M	SET SCREW M10-1.5 X 16
455	P0524455	FENCE
456	P0524456	COVER
457	PFH06M	FLAT HD SCR M6-1 X 20
458	P0524458	SAFE COVER

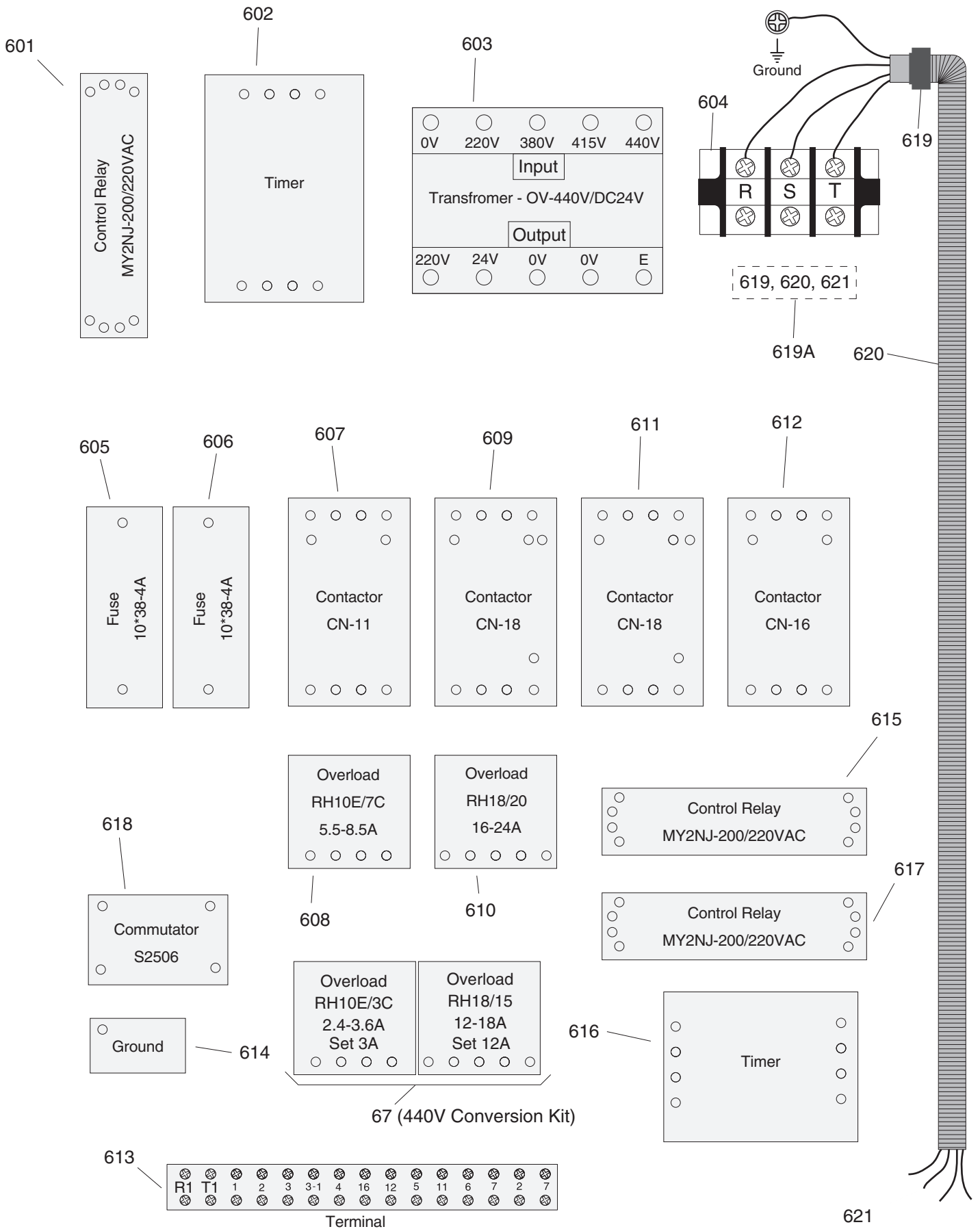
Hole Pattern For  
Arm Attachment



REF	PART #	DESCRIPTION
501	P0524501	SPRING PLANK
502	P0524502	SHAFT
503	P0524503	BEARING COVER, RIGHT
504	P6003	BALL BEARING 6003
505	PW03M	FLAT WASHER 6MM
506	PS14M	PHLP HD SCR M6-1.0 X 12
507	P0524507	ROLLER, RIGHT
508	P0524508	ROLLER, LEFT

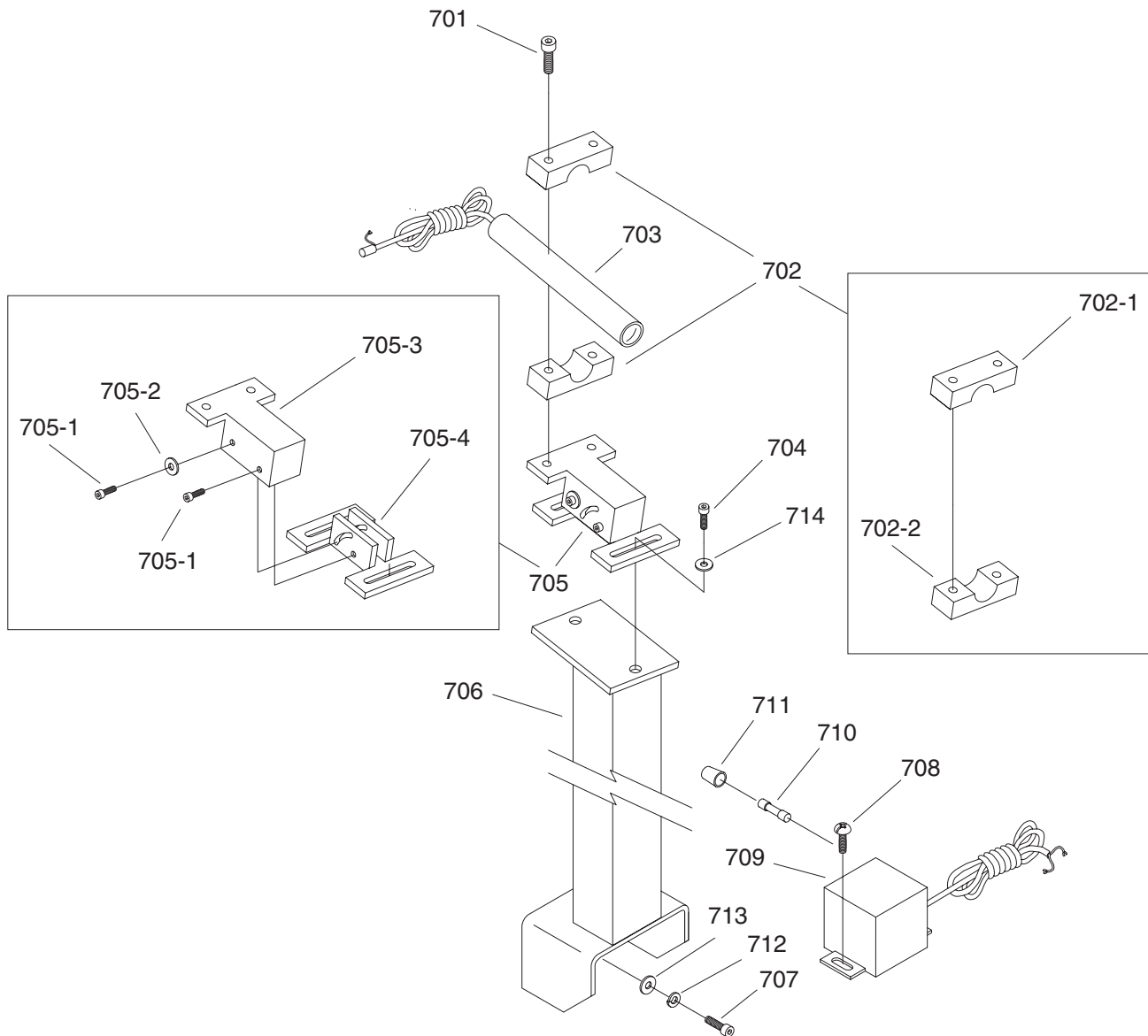
REF	PART #	DESCRIPTION
509	PSB01M	CAP SCREW M6-1.0 X 16
510	P0524510	SPRING PLANK
511	PSS28M	SETSCREW M6-1.0 X 30
512	PN01M	HEX NUT M6-1.0
513	PSS28M	SETSCREW M8-1.25 X 30
514	PN03M	HEX NUT M8-1.25
515	PLW03M	LOCK WASHER 6MM
516	P0524516	BEARING COVER, LEFT





REF	PART #	DESCRIPTION
601	P0524601	RELAY MY2NJ-200/220VAC
602	P0524602	TIMER
603	P0524603	TRANSFORMER 0V-440V/DC24V
604	P0524604	TERMINAL PLATE
605	P0524605	FUSE 10*38-4A
606	P0524606	FUSE 10*38-4A
607	P0524607	CONTACTOR CN-11
608	P0524608	OVERLOAD RH10E/7C 5.5-8.5A
609	P0524609	CONTACTOR CN-18
610	P0524610	OVERLOAD RH18/20 16-24A
611	P0524611	CONTACTOR CN-16

REF	PART #	DESCRIPTION
612	P0524612	CONTACTOR CN-11
613	P0524613	TERMINAL
614	P0524614	GROUND
615	P0524615	RELAY MY2NJ-200/220VAC
616	P0524616	TIMER
617	P0524617	RELAY MY2NJ-200/220VAC
618	P0524618	COMMUTATOR S2506
619	P0524619	STRAIN RELIEF
619A	P0524619A	WIRING HARNESS ASSEMBLY
620	P0524620	CONDUIT
621	P0524621	POWER WIRES



REF	PART #	DESCRIPTION
701	PSB48M	CAP SCREW M6-1.0 X 35
702	PH5749702	LASER CLAMP ASSEMBLY
702-1	PH5749702-1	LASER CLAMP (TOP)
702-2	PH5749702-2	LASER CLAMP (BOTTOM)
703	PH5749703	LASER
704	PSB01M	CAP SCREW M6-1.0 X 16
705	PH5749705	LASER BRACKET ASSEMBLY
705-1	PSB18M	CAP SCREW M4-0.7 X 8
705-2	PW05M	FLAT WASHER 4MM
705-3	PH5749705-3	LASER BRACKET (TOP)

REF	PART #	DESCRIPTION
705-4	PH5749705-4	LASER BRACKET (BOTTOM)
706	PH5749706	STEEL ARM
707	PSB31M	CAP SCREW M8-1.25 X 25
708	PS05M	PHLP HD SCR M5-0.8 X 8
709	PH5749709	POWER BOX
710	PH5749710	FUSE T1AL250V
711	PH5749711	FUSE COVER
712	PLW04M	LOCK WASHER 8MM
713	PW01M	FLAT WASHER 8MM
714	PW03M	FLAT WASHER 6MM

# Troubleshooting

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Motor will not start.	<ol style="list-style-type: none"> <li>1. Low voltage.</li> <li>2. Open circuit in motor or loose connections.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check power line for proper voltage.</li> <li>2. Inspect all lead connections on motor for loose or open connections.</li> </ol>
Motor will not start; fuses or circuit breakers blow.	<ol style="list-style-type: none"> <li>1. Short circuit in line cord or plug.</li> <li>2. Short circuit in motor or loose connections.</li> <li>3. Incorrect fuses or circuit breakers in power line.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect cord or plug for damaged insulation and shorted wires.</li> <li>2. Inspect all connections on motor for loose or shorted terminals or worn insulation.</li> <li>3. Install correct fuses or circuit breakers.</li> </ol>
Motor overheats.	<ol style="list-style-type: none"> <li>1. Motor overloaded.</li> <li>2. Air circulation through the motor restricted.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load on motor.</li> <li>2. Clean out motor to provide normal air circulation.</li> </ol>
Motor stalls (resulting in blown fuses or tripped circuit).	<ol style="list-style-type: none"> <li>1. Short circuit in motor or loose connections.</li> <li>2. Low voltage.</li> <li>3. Incorrect fuses or circuit breakers in power line.</li> <li>4. Motor overloaded.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect connections on motor for loose or shorted terminals or worn insulation.</li> <li>2. Correct the low voltage conditions.</li> <li>3. Install correct fuses or circuit breakers.</li> <li>4. Reduce load on motor.</li> </ol>
Machine slows when operating.	<ol style="list-style-type: none"> <li>1. Belts loose.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten belts.</li> </ol>
Loud, repetitious noise coming from machine.	<ol style="list-style-type: none"> <li>1. Pulley setscrews or keys are missing or loose.</li> <li>2. Motor fan is hitting the cover.</li> <li>3. V-belts are defective.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect keys and setscrews. Replace or tighten if necessary.</li> <li>2. Tighten fan or shim cover.</li> <li>3. Replace V-belts.</li> </ol>
Hand wheels will not turn.	<ol style="list-style-type: none"> <li>1. Hand wheel key is inserted too far.</li> <li>2. Bullets are wedged.</li> <li>3. Roll pin or setscrew in worm gear is contacting geared trunnion.</li> </ol>	<ol style="list-style-type: none"> <li>1. Remove hand wheel and adjust key.</li> <li>2. Remove hand wheel and adjust bullets.</li> <li>3. Inspect roll pins and setscrews in the worm gear. Tighten if necessary.</li> </ol>



# G0524 Wiring Diagrams

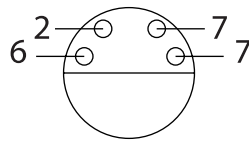
## **⚠ DANGER**

Disconnect power from machine before performing any electrical service. Failure to do this will result in a shock hazard, leading to injury or death.

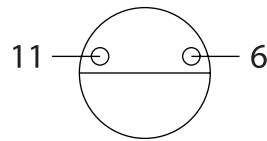
NOTE: THE WIRES FROM THE POWER SUPPLY, EXCEPT THE GREEN GROUND WIRE, ARE INTERCHANGABLE, THEREFORE COLORS ARE NOT SPECIFIED.

## Control Panel (Back-Side)

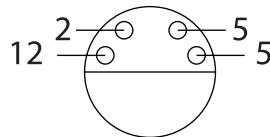
Power Light



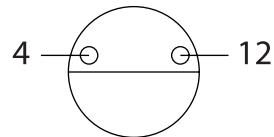
Emergency Stop



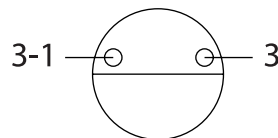
Saw Blade Stop



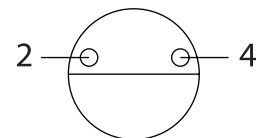
Saw Blade Start

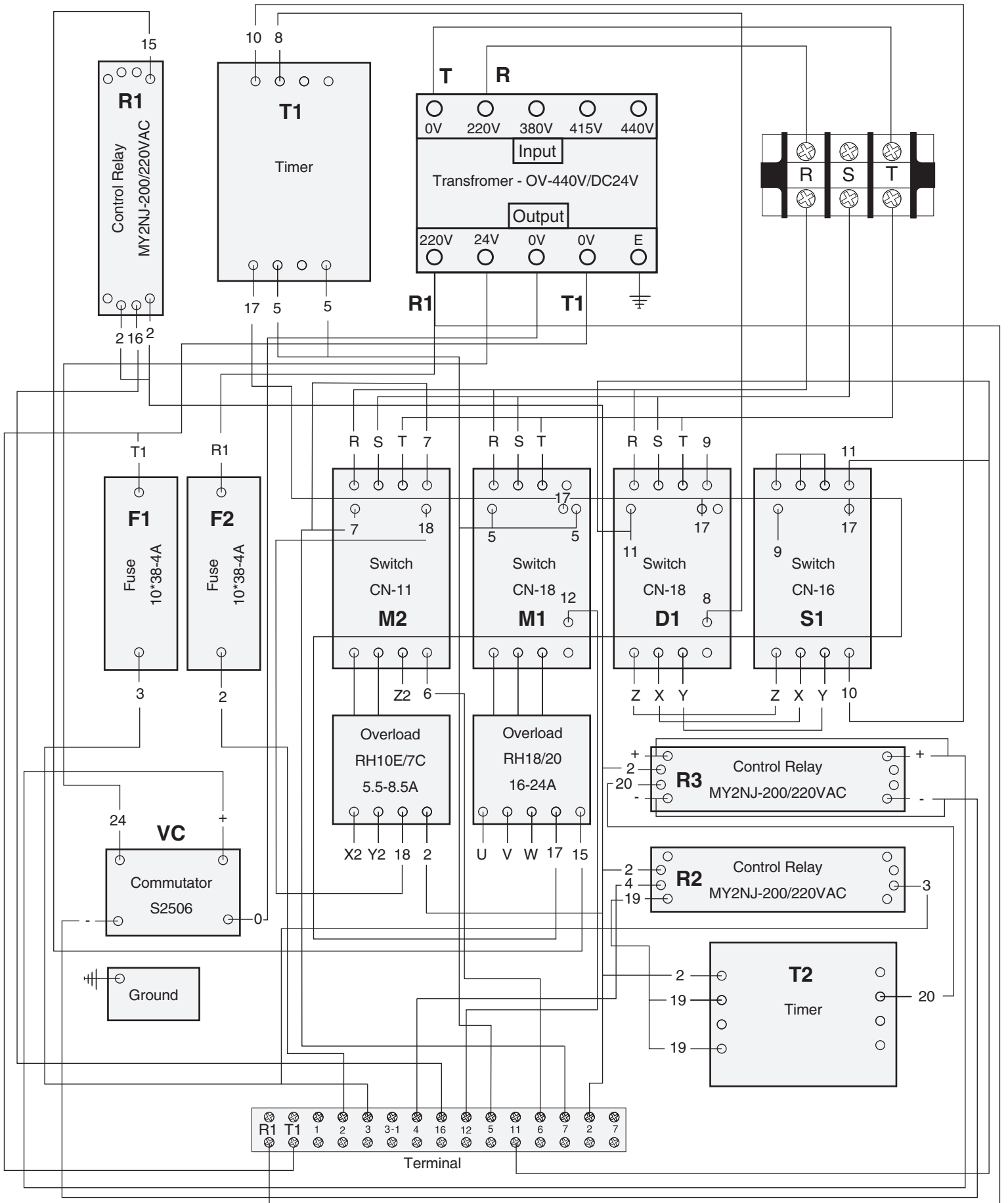


Conveyor Stop



Conveyor Start





# Notes

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# Warranty & Returns

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Grizzly Industrial, Inc. warrants every product it sells for a period of 1 year to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.





# WARRANTY CARD

Name \_\_\_\_\_  
Street \_\_\_\_\_  
City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
Phone Number \_\_\_\_\_ E-Mail \_\_\_\_\_ FAX \_\_\_\_\_  
MODEL # \_\_\_\_\_ Serial # \_\_\_\_\_ Order # \_\_\_\_\_

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

1. How did you learn about us? \_\_\_\_\_ Other \_\_\_\_\_  
 Advertisement  Friend  
 Catalog  Card Deck  
 World Wide Web  
\_\_\_\_\_  
 Other \_\_\_\_\_
2. Which of the following magazines do you subscribe to.  
 American Woodworker  Practical Homeowner  
 Cabinetmaker  Shop Notes  
 Family Handyman  Today's Homeowner  
 Fine Homebuilding  WOOD  
 Fine Woodworking  Wooden Boat  
 Home Handyman  Woodshop News  
 Journal of Light Construction  Woodsmith  
 Old House Journal  Woodwork  
 Popular Mechanics  Woodworker  
 Popular Science  Woodworker's Journal  
 Popular Woodworking  Workbench  
\_\_\_\_\_  
 Other \_\_\_\_\_
3. Which of the following woodworking/remodeling shows do you watch?  
 Backyard America  The New Yankee Workshop  
 Home Time  This Old House  
 The American Woodworker  Woodwright's Shop  
\_\_\_\_\_  
 Other \_\_\_\_\_
4. What is your annual household income?  
 \$20,000-\$29,999  \$60,000-\$69,999  
 \$30,000-\$39,999  \$70,000-\$79,999  
 \$40,000-\$49,999  \$80,000-\$89,999  
 \$50,000-\$59,999  \$90,000 +
5. What is your age group?  
 20-29  50-59  
 30-39  60-69  
 40-49  70 +
6. How long have you been a woodworker?  
 0 - 2 Years  8 - 20 Years  
 2 - 8 Years  20+ Years
7. How would you rank your woodworking skills?  
 Simple  Advanced  
 Intermediate  Master Craftsman
8. What stationary woodworking tools do you own? Check all that apply.  
 Air Compressor  Panel Saw  
 Bandsaw  Planer  
 Drill Press  Power Feeder  
 Drum Sander  Radial Arm Saw  
 Dust Collector  Shaper  
 Horizontal Boring Machine  Spindle Sander  
 Jointer  Table Saw  
 Lathe  Vacuum Veneer Press  
 Mortiser  Wide Belt Sander
9. How many of your woodworking machines are Grizzly? \_\_\_\_\_
10. Which benchtop tools do you own? Check all that apply.  
 1" x 42" Belt Sander  6" - 8" Grinder  
 5" - 8" Drill Press  Mini Lathe  
 8" Table Saw  10" - 12" Thickness Planer  
 8" - 10" Bandsaw  Scroll Saw  
 Disc/Belt Sander  Spindle/Belt Sander  
 Mini Jointer  
\_\_\_\_\_  
 Other \_\_\_\_\_
11. How many of the machines checked above are Grizzly? \_\_\_\_\_
12. Which portable/hand held power tools do you own? Check all that apply.  
 Belt Sander  Orbital Sander  
 Biscuit Joiner  Palm Sander  
 Circular Saw  Portable Planer  
 Detail Sander  Saber Saw  
 Drill/Driver  Reciprocating Saw  
 Miter Saw  Router  
\_\_\_\_\_  
 Other \_\_\_\_\_
13. What machines/supplies would you like Grizzly Industrial to carry?  
\_\_\_\_\_  
\_\_\_\_\_
14. What new accessories would you like Grizzly Industrial to carry?  
\_\_\_\_\_  
\_\_\_\_\_
15. What other companies do you purchase your tools and supplies from?  
\_\_\_\_\_  
\_\_\_\_\_
16. Do you think your purchase represents good value?  
 Yes  No
17. Would you recommend Grizzly Industrial to a friend?  
 Yes  No
18. Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**  
 Yes  No
19. Comments: \_\_\_\_\_

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**GRIZZLY INDUSTRIAL, INC.  
P.O. BOX 2069  
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